Appendix **O**Safety-Related Construction Inspection Plans

Appendix O

Safety-Related Construction Inspection Plans

System	Drawing	Description	Plan Number	Rev.	Status	Comments
N/A	A-5	· · · · · · · · · · · · · · · · · · ·		N/A	N/A	NO ACTION REQUIRED PER SURVEILLANCE 1 178
N/A	A-9	PHASE 2 INSTALLATION	NIA	N/A	N/A	NO ACTION REQUIRED PER SURVEILLANCE 1 178
CAS	S-8	CAS FRAMES/SUPPORTS	21052-S-08	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1 178
	s-10	LIGHT/ALARM POLE SUPPORTS				
	S-11	CAS LIGHT/HORN SUPPORTS				
RCS	P-11	RCS (DUST SUPP) BULKHEAD FITTINGS	2 1052-M-04	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
	FP-8	RCS (FIRE PROT) BULKHEAD FITTINGS				
	E-22	RCS ELECT. PENET SEAL WELDS				
	LSS-6	RCS ELECT. PENET SEAL WELDS		1.		
FFS	FP-10	FLOOR STRUCTURE (FIRE PROT) PENETRATIONS	21052-S-01		CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
I&V	HV-2	HVAC FLOW DIAGRAM	21052-V-02	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1 178
	HV-6	HVAC VENTILATION FLOOR PLAN		1		
		HVAC DETAILS & SECTIONS				
		HVAC DETAILS & SECTIONS			1	1
		HVAC DETAILS & SECTIONS		1		

System	Drawing	Description	Plan Number	Rev.	Status	Comments
CAS	IN-13	CAS CONDUIT AND CABLE	21052-E-01)	CLOSED	CORRECTIONS REQUIRED PER SURVEILLANCE 1178
	IN-16	CAS CABINET & WIRE SCHEDULE			1	
	IN-18	CAS WIRING				
	IN-19	CAS CONTROL ENCLOSURE ASSEMBLY				
	IN-20	CAS DETAILS				
FFS	s-2	HANDRAIL DROP-INS (WELDING TO FLOOR)	21052-S-10)	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
PGS	APP. A	PACKAGING GLOVEBOX SYSTEM INSTALLATION	21052-M-03)	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
	1522001		1			
	522004					
EXCAVATOR	APP. C	BACKHOE INSTALLATION	21052-S-07)	CLOSED	NO ACTION REQUIRED PER SURVETLLANCE 1178
	5 19933					
WES	E-22	WES LINER PENETRATIONS	21052-M-05)	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
FFS		FACILITY STRUCTURES	21052-M-01	3	CLOSED	CORRECTIONS REQUIRED PER SURVEILLANCE 1178 TRANSMITTAL 03-103A
STACK		STACK INSTALLATION	2 1052-M-02)	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
N/A		MOCKUP	21052- MOCKUP-01)	CLOSED	CORRECTIONS REQUIRED PER SURVEILLANCE 1178
VARIOUS		RECEIPT INSPECTION (WELD ROD UPGRADE)	21052-R-01)	CLOSED	CORRECTIONS REQUIRED PER SURVEILLANCE 1178 TRANSMITTAL 02-0038A

System	Drawing:	Description	Plan Number	Rev.	Status	Comments
VARIOUS		RECEIPT INSPECTION (STEEL EST/WARBONNET/3D/ATLAS)	21052-R-02	3	CLOSED	CORRECTIONS REQUIRED PER SURVEILLANCE 1178 TRANSMITTAL 03-108A
CAS		RECEIPT INSPECTION (CAS CONTROL ENCLOSURE ONLY)	21052-R-03	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
CAS		CRITICALITY DETECTOR CLUSTER FRAME-SHOP	21052-S-02	0	CLOSED	CORRECTIONS REQUIRED PER SURVEILLANCE 1178 TRANSMITTAL 03-011A
CAS		CRITICALITY CONSOLE HOUSING FRAME-SHOP	121052-S-03	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
CAS		LIGHT/ALARM POLE SUPPORTS-SHOP	21052-S-04	1	CLOSED	CORRECTIONS REQUIRED PER SURVEILLANCE 1178 TRANSMITTAL 03-013A
CAS		CRITICALITY ALARM SUPPORTS- SHOP	21052-S-05	0	CLOSED	CORRECTIONS REQUIRED PER SURVEILLANCE 1178 TRANSMITTAL 03-014A
FFS		DCN FS-19	21052-S-06	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1 178
H&V		SST DUCTWORK-SHOP	2 1052-V-01	0		CORRECTIONS REQUIRED PER SURVEILLANCE 1178 TRANSMITTAL 03-102A
RCS		ICR-065 RCS PANEL REPAIR	121052-M-07	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
RCS		ICR-062 RCS PANEL REPAIR	21052-M-06	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
WES		ICR-041 WES SNOW SHIELDS	21052-M-08	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178

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System	Drawing	Description	Plan Number	Rev.	Status	Comments
FFS		DCN FP-17	21052-S-09	0		NO ACTION REQUIRED PER SURVEILLANCE 1 178
FFS		FCR-13233-90 SST PLATE	21052-M-10	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
PGS		GLOVEBOX TESTING	21052-M-11	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
CAS		FCR-13233-118 and 13233-96MISC. ELECTRICAL ITEMS	21052-R-04	0	CLOSED	NOT REVIEWED DURING SURVEILLANCE 1 178-NO ACTION TAKEN
WES		WES ARCHITECTURAL FABRIC	21052-R-05	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
FFS		FCR-13233-76 STUD WELDS	21052-S-11	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
PGS		PGS #2 NCR-30108 REWORK	21052-S-12	0	CLOSED	NOT REVIEWED DURING SURVEILLANCE 1178-NO ACTION TAKEN
RCS		RCS PENETRATIONS AND TEK SCREWS INSTALLATION	21052-M-18	0		NO ACTION REQUIRED PER SURVEILLANCE 1178
FFS		DCN FS-28 SEAL WELDS	21052-M-17	О	CLOSED	CORRECTIONS REQUIRED PER SURVEILLANCE 1178
RCS		MISC. RCS PENETRATIONS FCR-13233- 190 AND TEK SCREWS	21052-R-07	1		NO ACTION REQUIRED PER SURVEILLANCE 1178
RCS		RCS LEAK TESTING	21052-M-12	1	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
H&V		STAINLESS STEEL DUCT SPOOL PIECE PER DCN FS-84	21052-V-03	0		NO ACTION REQUIRED PER SURVEILLANCE 1178
STACK		STACK BOLT INSPECTION	21052-M-19	О		NO ACTION REQUIRED PER SURVEILLANCE 1178
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System	Drawing	Description	Plan Number	Rev.	Status	Comments
VARIOUS		SAFETY SIGNIFICANT DIMENSIONS	21052-M-16	0		NOT REVIEWED DURING SURVEILLANCE 1178-NO ACTION TAKEN
FFS		TOOL TABLE WELDS	21052-S-15	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
RCS		DCN FP-47 CGI AND SEAL WELDS	21052-M-13	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
FFS		DCN FP-52 BOLTS	21052-M-14	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
RCS		FCR 13233-137 GASKET REPAIR	21052-M-15	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
EXCAVATOR		FCN-13233-153 KEEPER CLIPS	21052-S-13	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
CAS		MISC. CAS ITEMS	21052-R-06	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE I 178
RCS		FCR-13233-147 RCS BASE ANGLE	21052-S-14	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
RCS		ICR-066 PATCHES	21052-M-09	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
EXCAVATOR		SWING STOPS	21052-S-16	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
WES		NCR-31148 FRENCH CAN'S	21052-M-20	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178

CONSTRUCTION INSPECTION PLANNING PACKAGE

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Final QE Review:_

Date: 4-11-03

7/WHM-19-0030

WO/SC/PO No. 021052 Requester: Steve Davies Requester Approval: STEVE DAVIES PEC TON HIPP

Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (CAS/POLE SUPPORT INSTALLATION EXAMPLED DATED Floor Structure is safety significant (Q2) WES is low safety consequence (Q3) / RCS is safety significant (Q2) / RCS Release Date: 1-16-0-3

P No.	21052-S-08	jRev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.0	General	TDD 6416	100%	West'y that Pessipt Inspection has been performed per 21052-R-02 on the items being inspected.	3-13-03
'2.0	Structural Steel and Misc. Metals	15100 and DrawingS-8, S- 10 and S-11	Verify Random Checklist 414.A15	Verify that the structural steel is erected / installed per the approved drawings. Record IR number: 0 2-1052-25-	3-15-03 CEK
2.1		5100 and Drawing \$-10	Verify Random	Verify that Grade 8 bolted connections have been installed and torqued per manufacturers recommendations. Record IR number: 2052-5700	3-15-03 CEK
3.0	Structural Steel and Misc. Metal	5100 and Drawing S-10	Verify 100%	Verify that the welders are qualified to perform the welding process and have a current qualification.	3-13-03 CEX
3.1		5100 and DrawingS-10	Verify 100%	Record IR number. 02/0(2-5-/00 Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number: 02/0(5-6-/00)	3-13-03 CEK
3.2		5100 and DrawingS-10	Verify 100%	Record IR number: 02/05 5'-00 Verify that the welding process is being performed in accordance with the parameters defined in the WPS, including the following a) base metal preparation 3-13-35 b) cleaning 3-13-35 c) preheat temperature 3-13-03 d) interpass temperature 3-13-03 e) temporary welds 3-12-03 f) backing strips/runoff tabs 17-13 g) ioint preparation 1/24 Record IR number. 12-10-55-	3-13-03 CEK

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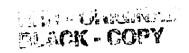
IP No. :	21052-S-08	Rev. 0		Later Sept. and Frances and	
ltem No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete initial/Date
3.3	Structural Steel and Misc. Metal	5100 and Drawing S-10	Verify 100%	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 02/052-5-100	3-13-03 CEK
3.4	Structural Steel and Misc. Metal	5100 and Drawing S-10	TPR-4981, Appendix D Visual 100% Static Loaded HOLD POINT		3-13-03 CEL
14.0	Structural Steel and Misc. Metal	MCP-9110	Yerily Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: (2) 2/052-75-/00	3-13-03 FEK
5.0	General	MCP-9436 App. A, B & C	Verify Random Checklist 414.A33	Verify that materials / items are segregated based on quality level, with no comingling of quality levels. Record IR number: 0210555760	3-13-03 CEK
5.1	General	MCP-9435 App. A, B & C And STD-7006	Verify Random Checklist 414.A33	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: 62.052-5-106	3-13-03 CEK
6.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	3-13-05

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORYON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPTIVELDING SHAUBE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE PEFOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTIONREPORT AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDETRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION/ ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOWMENTS THAT WILL PROVIDE TRACEABLITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: **BATCH TICKETS).**
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.

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- 8) NCR/DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED. AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".
- 15) CHECKUST 414.A15 IS BEING PILOTED INTHIS INSPECTION PLAN (REF. TPR-4921), AND SUBJECT TO CLARIFICATION / REVISION DURING THE
- CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE GE AND THE RE.

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Final QE Review:

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Date: 4/21/0.3

WO/SC/PO No. 021052 Requester: Steve Davies Requester Approval: KAREN SWLOPSHIPE OE: Ron Staymates 11/11/02 Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (RCS PENETRATION ACTIVITIES) Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2) / WeS later 12-20-02					
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (RCS PENETRATION ACTIVITIES) Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2) / WES Release Date: 12-20-02	WO/SC/PO No. 021052	Requester: Stave Davies	Requester Approval: KAZEN SNEOPSHIREPE	QE: Ron Stayr	nates 11/11/02 4
	Activity/Project Description: OU 7-10 G Floor Structure is safety significant	Novebox Excavator Method Fr (Q2) / WES is low safety con	acility (RCS PENETRATION ACTIVITIES) 2007/16 sequence (Q3) / RCS is safety significant (Q2) /3		12-20-02

IP No. 2	210 52-M -04	Rev. 0			
item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. [ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELL 3 PROCESSES SHAUBE DOCUMENTED ON FORMS 432.44 AND 432.	
			Ì	OR FORM 432.43 OR THE DRAWINGS.	
1.0	General	¹ PR-6416	Verify 100%	Verify that Receipt inspection has been performed per 21052-R-02 on the items being inspected. See TP 21052-R-02	CER
. 1.0	RCS Seal Welds	()rawing E-22, I.SS-6, FCR 13233-61 and DCN -FP-18	Verify 100%	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: 02-105-M-///	4-16-03 CEL
1.1	RCS Seal Welds	Drawing E-22, LSS-6, FCR 13233-61 and DCNFP-18	Verity 100%	Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number: 02/05-M-///	4-16-8 CEK
1.2	RCS Seal Welds	Drawing E-22, LSS-6, FCR 13233-61 and DCN -FP-18	Verify 100%	Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number: 02/05-M-// Verify that the welding process is being performed in accordance with the parameters defined in the WPS, including the following: a) base metal preparation CFF 4-16-03 b) cleaning > CFF 4-16-03 c) preheat temperature of interpass temperature of interpass temperature of temporary welds f) backing stripe/runoff teba/4-16-03 Record IR number: 21-05-M-// Record IR number: 21-05-M-//	4-16-03 CEL

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IP No. 2	21052-M-04	Rev. 0					
item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date		
	RCS Seal Welds	LSS-6, FCR 18233-61 and DCN -FP-18	Verify 100%	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 02/052-M-///	4-16-03 CEL		
1.5	RCS Seal Welds	Drawing E-22, LSS-6, FCR 13233-61 and DCN -FP-18	TPR-4981 Visual 100% Static Loaded HOLD POINT	Visually inspect welds per AWS D1.6. (copy attached) NOTE: Weld size is not applicable for this inspection, only the weld quality is critical. Record IR Number: 02/052 - M -///	4-16-03 CER		
	RCS Bulkhead Fittings	Drawing P-11, HV-6 and FP-8 FCR-13233-22	Verity Random	Verily that the bulkhead fittings have been installed per the approved drawings. Record IR number: 62/052- M -///	4-16-03 CEL		
	RCS FP Penetration Transfer Vestibule Celling	FCR 13233-71	Verify Random	Verify that the penetration installation is in accordance the FCR, including opening size, silicone sealant and use of the Grinnell Figure 395 ceiling plate. Record IR number: 02-1052 - M-///	41-16-03 CEL		
i	RCS FP Penetration Personnel Access Area Wall	FCR 13233-71	Verify Random	Verify that the penetration installation is in accordance the FCR, including opening size, silicone sealant and use of the Grinnell Figure 395 ceiling plate. Record IR number: 02/053-M-//	4-16-03 CEK		
	RCS FP Penetration Personnel Monitoring Area Wall	FCR 13233-71	Verify Random	Verify that the penetration installation is in accordance the FCR, including opening size, silicone sealant and use of the Grinnell Figure 395 ceiling plate. Record IR number: 02/052-M	U-16-03 CEK		
	Structural Steel and Misc. Metal	MCP-9110	Verily Random	Verify that no suspect / counterfelt Items have been utilized. Record IR number: /> 2-/0 (2-M-///	4-1603 CEL		
5.0	General	MCP-9436 App. A, B & C	Verify Random Checklist 414.A33	Record IR number: 02/055-M-/// Verity that materials / items are segregated based on quality level, with no comingling of quality levels. Record IR number: 02/055-M-///	41-16-03 CEL		
5.1	General	MCP-9436 App. A, B & C And STD-7006	Verify Random Checklist 414.A33	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier)	4-16-03 CEK		
6.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure. O 2/0 C2-M /// 22-0357993 LMIT	4-16-53		

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09/08/97 Rev. #01

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INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS. EXCEPT WELDING SHALL BELLOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE OF FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 VISUAL INSPECTION REPORT* AND ATTACHED TO THE APPLICABLE CIP OR ON THEWELD HISTORY RECORDS (FORM 432.43, 492.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESÍGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATIONOF INSPECTIONS PERFORMED (IE: BATCHTICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE RATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS SEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR NIA'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN IN TIALED AND DATED.
- 11) VERIFYTHAT APPLEABLE VDS DOCUMENTSHAVE BEEN APPROVED OR SUBMITTED AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS-
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM M E FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - BI ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A GENERAL INSPECTOR.
- 15) CHECKLIST 414.A15 IS BEING PILOTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE.

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Final QE Review:

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Date: 4-9-03

WO/SC/PO No. 021052

Requester: Steve Davies Requester Approval: Louis Guiusa Pacamatica QE: Ron Staymates 12/04/02

Activity/Project Description: QU 7-10 Glovebox Excavator Method Facility (Fire Protection Pipe Sleeves per FCR 13233-48)

Floor Structure is safety significant (Q2) / RCS is safety significant (Q2)

IP No. 2	1052-8-01	Rev. 1	Rev. 1. incorporated FCR	13233-48	
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference.	Instructions	Complete Initial/Date
	Equipment	Neleien		SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL WELDING PROCESSES TO THE FLOOR STRUCTURE SHALL BE	N/A
1.0	Structural	5060, pg 3 line	Verify	DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS. Verify that the welders are qualified to perform the welding process and have a	2-5-05
1.0	Welding Per Drawing 522704 & 705	25 thru 36	100%	NOTE: Receipt Inspection per Inspection Plan 21052-R-01 is required for the weld rod. Record IB number: (12.10.52 - P - 04/)	CER
1.1	Structural Welding Per Drawing 522704 & 705	5060, pg 4 line 30 thru 37	Verify Random	to a CMTR and has been approved in the vendor data system. Record IR number:	2-5-03 CER
1.2	Structural Welding Per Drawing 522704 & 785	5060, pg 5 line 11 thru 44 & pg 6 line 1 thru 35	Verify Random	Verify that the welding process is being performed in accordance with the parameters defined in the approved vendor data WPS, including the following: a) base metal preparation 2 - 5 - 03 CEX b) cleaning 2 - 5 - 03 CEX c) preheat temperature 2 - 5 - 03 CEX d) interpass temperature 3 - 5 - 03 CEX e) temperary welds f) backing strips/runoff labs NA g) joint preparation 2 - 5 - 03 CEX Record IR number: 01 10 53 P-04	2-8-03
1.3	Structural Welding Per Drawing	5060, pg 6 line 37 thru 42 & pg 7 line 1 thru 12		Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: 01051-1052-1099	2-5-03 CFL

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Page 2 of 3

IP No.	21052-S-01	Rev. 1	Rev. 1. Incorporated FCR	13233-48	. :
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.4	Structural Welding Per Drawing 522704 & 705	5060, pg 7 line 14 thru 17	Verify Random	Verify that are strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Are strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 72/052-294/	2-3-03 CEL
1.5	Structural Welding Per Drawing 522704 & 705	5060, pg. 7 line 34 thru 38	TPR-4981, Appendix D Visual 100% Static Loaded HOLD POINT	Record IR number: 02/052-0-94/ Visually inspect pipe sleave welds per AWS D1.1. Record IR Number: 02/052-0-94/	2-3-03 CFK
2.0	General	MCP-9110	Verify Random	Verify that no suspect / counterleit items have been utilized. Record IR number: 02/052-P-04/	2-3-33
3.0	General	MCP-9436 App. A, B & C	Verity Random Checklist 414.A33	Verify that materials / items are segregated based on quality level, with no comingling of quality levels. Record IR number: 02/052-P-04/	2-3-03 CER
4.0	General	MCP-9436 App. A, B & C And STD-7006	Verify Random Checklist 414.A33	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: 02/052-9-04/	5-3-03 CEL
5.00	General	MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure. $\beta 2.052-P-041$	2-3-03

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.05, QUALITY INSPECTION REPORT AND ATTACHED TO THE APPUCABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 VISUAL INSPECTION REPORT AND ATTACHED TO THE APPUCABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDETRACEABILITY TO THE ITEM.
- 5) ANY DESÍGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION ACCEPTANCESHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABLITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCHTICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.

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- 8) NCR/DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR NIA'D.
- 10) ALL LINE-OUTS ORWRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLECABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLTTORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT/WUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTÀTIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A GENERAL INSPECTOR*.
- 15) CHECKLIST 414.A15 IS BEING PILOTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION/REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF MEDIC AND THE RE.

414,81# 09/08/97

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Date: Final QE Review: 200 WO/SC/PO No. 021052 Requester: Steve Davies Requester Approval: Louis Routen Fol EMAN ACTIVITIES)

Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (HVAC INSTALLATION ACTIVITIES)

132_1 QE: Ron Stavmates 11/11/02 1 Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (HVAC INSTALLATION ACTIVITIES)
Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2)
Release Date:

IP No. 2	21052-V-02	Rev. 0]		
Item No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
	. 1			SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS.	
1.0	General	TPR-6416	Verify 100%	Verify that receipt inspection has been performed per inspection plan 21052-R- 02 for the HVAC Dectwork upon arrival at site. Record IR number:	r
1.0	Stainless Steel Ductwork FIELD WELDS ONLY	15014	Verify Random	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number:	·
1.1	Stainless Steel Ductwork FIELD WELDS ONLY	15014	Verify Random	Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number:	
1.2	Stainless Steel Ductwork FIELD WELDS ONLY	15014	Verity Plandom	Verify that the welding process is being performed in accordance with the parameters defined in the WPS, including the following: a) base metal preparation b) cleaning c) preheat temperature d) interpass temperature e) temporary welds f) backing strips/runoff tabs g) joint preparation Record IR number:	

NO STAINLESS STEEL DUCT WELDING PERFORMED IN THE
FIELD. Fry Staymater 4/8/03

CER 4-8-03

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IP No. 2	21052-V-02	Rev. 0		EPACK - Obst	
item No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1,3	Stainless Steel Ductwork FIELD WELDS ONLY	15014	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number:	
1.4	Stainless Steel Ductwork FIELD WELDS ONLY	15014	Verify Random	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number:	
1.5	Stainless Steel , Ductwork : FIELD WELDS ONLY	15014	TPR-4981 Visual 100% Static Loaded HOLD POINT	Visually inspect welds per AWS D9.1.(copy attached) Record IR Number	
2.0	Stainless Steel Ductwork FIELD WELDS ONLY	15014	TPR-4975, Appendix C Visual 100%	Liguid Penetrant examine the final pass on all welds, using water washable removable dutor contrast penetrant. Acceptance criteria will be defined on a design charge document (DCN / FCR). Record IR number:	
3.0	Stainless Steel Ductwork	15014 and Drawings HV-6, 7, 8, 10 See HV-3, 4, 5 & 9 for general location information	Verity Random Checklist 414.A30 item 1.1, 2.1, 2.3, 2.4, 2.5, 2.6, 2.7, 2.8, 2.9, 3.3, 3.5, 3.8, 3.9 and 4.1 only	Verify that the ductwork is erected per the approved shop drawings. Record IR number:	
3.1	Stainless Steel Ductwork	15614 and Drawings HV-7	Verify Random Checklist 414.A30 Item 1.1, 2.1, 2.3, 2.4, 2.5, 2.6, 2.7, 2.8, 2.9, 3.3, 3.5, 3.8, 3.9 and 4.1 only	Verify that the HEPA Filters, Moisture Separators and Pre-Filters are installed per drawing HV-7 Record IR number:	

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IP No. :	21052-V-02	Rev. 0			
item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
3.2	Stainless Steel Ductwork	15014 and Drawings HV-7	Verify Random Checklist 414.A30 Item 1.1, 2.1, 2.3, 2.4, 2.5, 2.6, 2.7, 2.8, 2.9, 3.3, 3.5, 3.6, 3.9 and 4.1 only	Verify that the motorized damper (HV-DMP-52) is installed per drawing HV-7. Record IR number:	
4.0	Stainless Steel Ductwork	MCP-9110	Verify Random	Verify that no suspect / counterfelt items have been utilized. Record IR number:	
5.0	General	MCP-9436 App. A, B & C	Verify Random Checklist 414.A33	Verify that materials / items are segregated based on quality level, with no co- mingling of quality levels. Record IR number:	•
5.1	General	1. 10 E	Verify Flandom Checklist 414.A33	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number:	
6.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) A UINSPECTIONS, EXCEPTWELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPUCABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION WALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON M.R. M.414.04 VISUAL INSPECTION REPORT* AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (MR.M.432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTIOW/ ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- B) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABLITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION W E DATES HAVE BEEN RECORDED.
- 8) NCA/DR INFORMATIONHAS BEEN RECORDED PER MCP-538/598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR NA'D.

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- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT/COUNTERFEIT PARTS OR COMPONENTS PER IMCP-9110.
- 14) ALL ATTRIBUTES INTHIS PLAN, EXCEPTN OSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".
- 15) CHECKUST 414.A15 IS BEING PILOTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE,

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\$14.81# * 09/08/97	CONSTRUCTION INS	SPECTION _	ANNING PACKAGE	451	o- ofigila	ge 1 of 3
Rev. #01			111			
17 Rom #	Fil	nal QE Review:	Goy Sleyne	allt	Date: 4-7-0	<u>ろ</u>
WO/SC/PO No. 021052	Requester: Steve Davies	Requester Annsov	al: STOVE DAMES AND	DWA/L	QE: Ron Stavmates 12/20/02	A
Activity/Project Description: OU 7-10	Glovebox Excavator Method Fac	CHILL HANDRAIL	DROP-IN INSTALLATION)	18/12		~
Activity/Project Description: OU 7-10 Floor Structure is safety significant				18/03	Release Date: 1/10/03	

P No.	21052-S-10	Rev. 0	, ,		
Item No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
	,			SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION.	
	ڊ -			ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS.	
1.0	Structural Steel and Misc. Metal	5100 and Drawing S-2	Verify 100%	Verify that the welders are qualified to perform the welding process and have a current qualification. Record iR number: 02/055-5-092	2-26-0 CEK
1.1	Structural Steel and Misc. Metal	5100 and Drawing S-2	Verily 100%	Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number: 62/055-5'-652	2-26-83 CEL
1.2	Structural Steel and Misc. Metal	5100 and Drawing S-2	Verify 100%	Verify that the welding process is being performed in accordance with the parameters defined in the WPS, including the following: a) base metal preparation 2-26-05CEK b) cleaning CEK 2-26-03 c) preheat temperature VA d) interpass temperature VA e) temporary welds N-A f) backing strips/runoff tabs N-A g) joint preparation CEK 2-6-03 Record IR number: 02/052-5-052	3-26-03 CEK
1,3	Structural Steel and Misc. Metal	5100 and Drawing S-2	Verify 100%	Verify that are strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Are strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 02-1052-5-052	2-2603 CEK

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IP No. 2	21052-S-10	Rev. 0		·	
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.4	Structural Steel and Misc. Metal	5100 and Drawing S-2	TPR-4981, Appendix D Visual 100% Static Loaded HOLD POINT	Visually inspect weids per AWS D1.1 Stored IR Number: 02/052-8 092	2-26-0 CEK
2.0	Structural Steel and Misc. Metal	MCP-9110	Verify Random	Verify that no suspect / counterfelt items have been utilized. Record IR number: 02/052-5-092	2-2603 CFK
3.0	General	MCP-9436 App. A, B & C	Verify Random Checklist 414.A33	Verify that materials / items are segregated based on quality level, with no comingling of quality levels. Record IR number: クス/の、ケーンゲークタク	2-26-03 CER
3.1	General	MCP-9436 App. A, B & C And STD-7006	Verify Random Checklist 414.A33	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferrred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: (22-1) 52-3-052	2-16-03 CER
4.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	22603 EER

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP. THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, 'QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DATLY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE **QE FOR RESOLUTION.**
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.06 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION [HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION/ ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.05 OS NOTED ON THE APPLICABLE CIP ATTRIBUTE
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABUTY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCHTICKETS).
- 7) M& TE SERIAL NUMBERS AND CALIBRATION W E DATES HAVE BEEN RECORDED.
- 6) NCR / DR INFORMATIONHAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTSOR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.

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CONSTRUCTION INSPECTION LANNING PACKAGE

STATE OF COMMENTS

12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:

414,81# * 09v08/97 Rav. #01

A ANCHOR BOLT PLACEMENT

A) ANCHOR BOLT TORQUE

B) ANCHOR BOLT TORQUE

C) LOCATION

D) ELEVATION

E) ORIENTATION

E) ORIENTATION

13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.

14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".

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CONSTRUCTION INSPECTION PLANNING PACKAGE

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Final QE Review:

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Date: 4-7-03

WO/SC/PO No. 021052

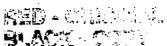
Requester: Steve Davies Requester Approval: R. CARPENDO POLDINAL QE: Ron Staymates 11/11/02

Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (GLOVEBOX INSTALLATION ACTIVITIES)

Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2)

Release Date: 1/2/0.3

P No. 2	21052-M-03	Rev. 0			
ítem No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATIONRELATIVE TO THIS INSPECTION. ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45	
1.0	Structural Welding Glovebox Number 1 Boot Attachment Welds	5060 and SPC- 389 Appendix A. Drawing 519895	Verify Random	OF?FORM 452.43 OR THE DRAWINGS. Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: 02/052-5-090	2-25-05 CER
1.1	Structural Welding Glovebox	5060 and SPC- 389 Appendix A, Drawing 519895	Verify Random	Verify that the filler metal is the correct type per the WPS and that it is traceable to e typical CMTR. Record IR number: 02/052-5-090	2-250 CEK
1.2	Structural * Welding Glovebox	5060 and SPC- 389 Appendix A, Drawing 519895	verify Random	Verify that the welding is being performed in accordance with the parameters defined in the WPS I cluding the wir a) base metal preparation (2 2 2 2 3 5 5 5 5 5 6 1 1 1 1 1 1 1 1 1 1 1 1 1 1	2-25-0) CER



∍ No.	21052-M-03	Rev. 0	1	BLACK CONTRACTOR	
No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.3	Structural Welding Glovebox Number 1 Boat Attachment Welds	389 Appendix A, Drawing	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single web Written approval is required to proceed with more than two repairs. Record IR number: 02/052-5-050	2-35-8 CFK
1.4	Structural Welding Glovebox Number 1 Boot Attachment Welds	5060 and SPC- 389 Appendix A, Drawing 518895	Verify Random	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 02/052-5'-050	2-25-03 CER
1.5	Structural Welding Glovebox Number 1 Boot Attachment Welds	5060 and SPC- 389 Appendix A, Drawing 519895	TPR-4981, Appendix <i>O</i> Visual 100% Static Loaded HOLD POINT	Visually inspect welds per AWS D1.1. Record IR Number: 0 2/055-5-050	2-25-03 CER
2.0	Structural Welding Glovebox Number 2 Boat Attachment Welds	5060 and SPC- 389 Appendii A, Drawing 519895	Verify Random	Verify that the welders are qualified to perform the welding process and have a current qualification. Record R number: 02/05/2-5-050	2-25-03 CER
2.1	Structural Welding , Glovebox Number 2 Boot Attachment Welds	5060 and SPC- 389 Appendix A, Drawing 514895	Verify Random	Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number: 0 2-1052-5-050	2-25-03 CER

item No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
2,2	Structural Walding Glovebox Number 2 Boot Attachment Welds	5060 and SPC- 389 Appendix A, Drawing 51.9835	Verify Random	Verify that the welding process is being performed in accordance with the parameters defined in the WPS, including the following: h) base metal preparation i) cleaning j) preheat temperature k) interpass temperature k) interpass temperature m) backing stripe/runoff labs m) backing stripe/runoff labs m) point preparation location (1) 1-25-3 Record IR number: Verify that the weld repairs are limited to a maximum of 2 (two) repairs on any labels used.	2-2503 CER
2.3	Structural Welding Glovebox Number 2 Boot Attachment Welds	5060 and SPC- 389 Appendix A, Drawing 519895	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record R number: 02/05 2-5-050	2-25-0. CER
2.4	Structural Welding Glovebox Number 2 Boot Attachment Welds	5060 and SPC- 389 Appendix A, Drawing 519895	Verify Random	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 In. of base metal shall be removed. Arc strikes exceeding more than 1/32 in into the base metal shall be considered as a weld defect and repaired as specified, Record IR number! 02-1052-5-050	2-15-0: CER
2.5	Structural Walding Glovebox Number 2 Boot Attachment Welds	5060 and SPC- 389 Appendix A, Drawing 519895	TPR-4981, Appendix D Visual 100% Static Loaded HOLD POINT	Record IR Number: 624052-5-050	2-25-63 CER
3.0	Sfructural Welding Glovebox Number 3 Boot Attachment Welds	5060 and SPC- 389 Appendix A. Drawing 519895	Verify Random	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: 024095-5'-090	2-25-03 CER

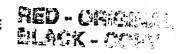
IP No.	21052-M-03	Rev. 0	,		
item No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
3.1	Structural Welding Glovebox Number 3 Boot Attachment Welds	5060 and SPC- 369 Appendix A, Drawing 519895	Verify Random	Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number: $02/052-5-090$	2-2503 CER
3.2	Structural Welding Glovebox Number 3 Boot Attachment Welds	5060 and SPC- 389 Appendix A, Drawing 519895	Verify Random	Verify that the welding process is being performed in accordance with the parameters defined in the WPS, including the following: o) base metal preparation CLL 2-25-03 p) cleaning q) preheat temperature r) interpass temperature CLL 2-25-03 s) temporary welds t) backing strips/runoff tabs NA u) joint preparation CLL 2-25-03 Record IR number: 22/052-3-080	2-2503 CEL
3.3	Structural Welding Glovebox Number 3 Boot Attachment Welds	5060 and SPC- 389 Appendix A, Drawing 519895	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: 02/052-5-050	2-25-03 CER
3.4		5060 and SPC- 389 Appendix A. Drawing 519895	Verify Random	Verify that an: strikes h u e bean ground to a smooth contour but na more than 1/32 ln. of base metal shall be removed. Arc strikes exceeding more than 1R2 in, into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 02/052-5-050	2-25-03 CER
3.5		519805	TPR-4981, Appendix D Visual 100% Static Loaded HOLD POINT	Visually inspect welds per AWS D1.1. Record IR Number: 02-1055-5'-050	2-25-03 CER



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item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Mathod/Procedure Reference	Instructions	Complete Initial/Date
4.0	Structural Steel and Misc. Metals Glovebox Number 1	Appendix A and	Verify Random Checklist 414.A15	Verify that the structural steel is erected per the erection plan, manufacturers recommendations and final approved shop drawings. Record IR number: 02/052-5-090	2-350 CER
5.0	and Misc. Metal Glovebox Number 2	5100, SPC-389 Appendix A and approved shop drawings Drawings A-1, A-5, A-8, P-9 AND P-10 for general location information	Verify Random Checklist 414.A15	Verify that the structural steel is erected per the erection plan, manufacturers recommendations and final approved shop drawings. Record IR number: 02/052-5-050	2-25-03 CER
6.0	and Misc. Metal Glovebox Number 3 Support Legs	5100, SPC-389 Appendix A and approved shop drawings Drawings A-1, A-5, A-8. P-8 AND P-10 for general location information	Verify Random Checkilst 414.A15	Verify that the structural steel erected per the erection plan, manufacturers recommendations and final approved shop drawings. Record R number: 02/052-50	7-25-03 CER
7.0	and Misc. Metals	5100, SPC-389 Appendix A and approved shop drawings	Verify Random	Verify that bolted connections have been installed per the manufacturers instructions. Record IR number: 62/052-\$ =050	2-75-03 CER

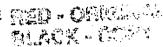
CONSTRUCTION INSPECTION PLANNING PACKAGE



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P No.	21052-M-03	Rev. 0			
I tem No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
8.0	Structural Steel and Misc. Metals Glovebox Number 2 Support Lags	5100, SPC-389 Appendix A and approved shop drawings		Verify that boltedconnections have been installed per the manufacturers instructions. Record IR number: 02-1059-5-090	2-25-03 CEL
9.0	{StructuralSteel	,	Verify Random	Verify that bolted connections have been installed per the manufacturers instructions. Record IR number: 02/055-5'-050	2-25-03 CER
10.0	Glovebox Number 1	Approved Shop Drawings Drawings A-1, A-5, A-8, P-9 AND P-10 for general location information	Verify Randorn Checklist 414.A29, item 1.1, 2.1, 2.3, 2.7, 2.8, 3.1, 3.2, 5.1 or 5.2 only	Verify that the glovebox, including windows and gloveports is re-assembled in accordance with the manufacturers instructions. Record IR number: 02/052-5-050	2-25-03 CEX
11.0	Glovebox Number 2	Approved Shop Drawings Drawings A-1, A-5, A-6, P-9 AND P-10 for general location Information	Random	Verify that the glovebox, including windows and gloveports is re-assembled in accordance with the manufacturers instructions. Record IR number: 02/052-5050	2-25-03 Clash
12.0	Glovebox Number 3	Approved Shop Drawings Drawings A-1. A-5, A-8, P-9 AND P-10 for general location information	Random	Verify that the glovebox, including windows and gloveports is re-assembled in accordance with the manufacturers instructions. Record IR number: 02/052-5-050	2-75-03 CFK
13.0	General	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: 2/052-5-050	2-25-03
14.0		MCP-9436 App. A, B & C	Verify Random Checklist 414.A33	Verify that materials / items are segregated based on quality level, with no comingling of quality levels. Record IR number: 02-(052-5-050)	2-95-03 CEL

CONSTRUCTION INSPECTION PLANNING PACKAGE (1) 20 - OPTICAL AND ADDRESS OF THE PACKAGE (1) 20 - OPTICAL AND ADDR



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IP No. 2	21052-M-03	Rev. 0			
item No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
14.1	General	MCP-9436 App. A, B & C And STD-7006	Verify Random Checklist 414.A33	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferrred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: 02/052-5-090	2-28-03 CER
15.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	2-25-63 CER

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP. THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELWING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLECIP, INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DALLY, ANY IN REQUIRING ACTION SHALL BE FORWARDED TO THE OF FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 VISUAL INSPECTION REPORT AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDELOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER. LINE NUMBER. ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABLITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCHTICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUT / OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT "PPLICABLE VDS DOCUMENTS HAVE BEEN APPROVE) OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - **B1 ANCHOR BOLTTORQUE**
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT/COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES INTHIS PLAN, EXCEPT THOSE THAT REQUIREA SPECIFIC QUALIFICATION. (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".

15) CHECKLIST 414.A15, A29 & A33 ARE BEING PILOTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE.

CONSTRUCTION INSPECTIC

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Page 1 of 3

Final QE Review: The SEE ASTRUMED NOTE US

Date: 4-2-23

WC/SC/PO No. 021052 Requester: Steve Davies Requester Approval: BUNC GROWERS SUBJECTION QE: Ron Staymates 11/11/02

Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (BACKHOE INSTALLATION ACTIVITIES)

Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2)

No.	21052-9-07	Rev. 0]		
tem No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS.	
1.C	Structural Welcing FIELD WELDS ONLY	5060 and SPC-389 Appendix C, drawing 519933	Verify Random	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: 02 (052-75-104)	4-2-03 CEL
1.1	Structural Welding FIELD WELDS ONLY	5060 and SPC-389 Appendix C, drawing 519933	Verfy Random	Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number: 02/052-54-/09	4-7-03 CFR
1.2	Structural Welding FIELD WELDS ONLY	5060 and SPC-389 Appendix C, drawing 519933	Verify Random	Verify that the welding process is being performed in accordance with the parameters defined in the WPS, including the following: a) base metal preparation b) cleaning c) preheat temporature d) interpass temperature e) temporary wolds e) backing strips/runoff table 11 g) joint preparation Record IR number:	4-2-03 CEL
	Structural Welding FIELD WELDS ONLY	5060 and SPC-389 Appendix C, drawing 519933	Verity 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number:	4-2-03 CEL

72	to the QE for closure,							
506-19	Hecord IR number: 01.05.7—7.04 Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	yline V	MCP-2482		0.7			
730	transfermed when material is subdivided. (transfer can be by marking, tagging or other unique identifier)	Checklist 414, A33			ļ.			
506-M	Verify that traceability markings (QA numbers, heat numbers, etc.) are	Verity Rendom	MCP-9436 App. A. B & C	General	r,B			
	Record IA number: 62-10,52-8	Checklist 414,A33	9670 0311	cases	- + 0			
730	mingling of quality levels.	mobrisA	App. A, B & C	ļ				
15000	Verity that materials / items are segregated based on quality lavel, with no co-	Verity	MCP-9436	i, lsnensi	0.8			
Soln	<i>№</i> 27 27 27 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	Rendom						
Soth	Verify that no suspect / counterfeit items have been utilized.	Verify	MCP-9110	S1908£	0.8			
صد.	1.1.1.10180		8701-NJ9 bna	1				
130	701-2-4501-60 medium Al brooms		EE6613 priwarb					
1-1-1-1	9201-N Id	%001	Appendix A,					
50-6-H	Verify that the outer boot has been installed to the RCS per the drawing and	Verify		Duter Boot	0.4			
730	1 A ST PONTO : BRITISH UI NIMANI	9 001	A xibneqqA, drawing 519933		ı			
80-6-H	Vertify that the shim material has been installed per the drawing.	100% 100%	SPC-389	smidS	9.0			
		ONEY		200;40	- 00			
1		2.8, 3.2, 5.1 or 5.2						
many	•	7.S.E.S.1.S.1.F mah						
750	Note; a pre-installation test is required per AISC.	end Checklist 414.A29,						
1-1-11	Verify that bolting has been torqued to the specified torque value. Record if number: 62-62-62-64	2001	A xibneqqA	_				
80-6-H	Verify that botting has been torqued to the apecified torque value.	Verify	SPC-389	s griffo8	2,0			
1		HOLD POINT						
130			EE8612 gniwerb	ONTA				
	LOIS S- 450/-CO Sequina vi pigger	Vieual 100%	A Appendix A,	LIEFD METDS				
SOLH	Visually inapect weids per Awa U.I.T.	Q xibneqqA ,1864-R9T	2080 and 5080 and	Structural Welding	5.1			
	Appendix On 10.57 - 104 Wisually inspect welds per AWS D1.1. Record IR Number: On 10.5 - 104 Record IR Number: On 10.5 - 104	G % 7 1007 UGL	P 0003	. 1				
ا مدا	peypeds		SE8613 gniws1b	ONEY				
2130	in. Into the base metal shall be considered as a weld defect and repaired as		Appendix A,	LIETD METDS				
	1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32	mobn a R	\$PC-389	∑ FribleW				
50-6-17	Verify that are strikes have been ground to a smooth contour but no more than	yineV	5060 and	Structural	Þ "k			
ets@\sitin!	,	Aeference	eoneneleA	Equipment	.oN			
Complete	enotiourieni	Method/Procedure	Chteria	Naterial or	meti			
	·		Acceptance	\medil\zeanor9				
•			0 . v eA	70-8-52012	; .oN 91			
Page 2 of 3	414.81# CONSTRUCTION INSPECTIC. ALANING PACKAGE GB/08/17 GB/08/17 GONSTRUCTION INSPECTIC. ALANING PACKAGE Page 2 of 3							
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INSPECTION PLAN GENERAL NOTES

414.81# 09/08/97 Rw.#01

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- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORYON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLANREQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3> WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, EIC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANCE DOCUMENTS UTILIZED FOR INSPECTION/ ACCEPTANCE SHALL ALSO BE DOCUMENTEDON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENT8 THAT WILL PROVIDE TRACEABLITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M& TE SERIAL NUMBERS AND CALIBRATION WE DATES HAVE BEEN RECORDED.
- 8) NCR/DR INFORMATION HAS BEEN RECORDED PER MCP-538/598.
- 9) ALL BLANKSHAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERSHAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED. AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHAU INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT/ COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL **ATTRIBUTES IN** THIS **PLAN**, EXCEPT THOSE **THAT** REQUIRE A SPECIFIC **QUALIFICATION**, **(I.E.** WELDING, **NDE**, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A GENERAL INSPECTOR*,
- 15) CHÉCKLISTS ARE BUNG PILOTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE.

			CONSTRUCTION IN	ISPECTION ANNING PACKAGE		age 1 of 3
			F	Final QE Review:	Date:	
Activity/	PO No. 021052 Project Description tructure is safety	: OU 7-10 Glow	ebox Excavator Method F	Requester Approval: K	,	11/11/02 RS#
IP No. 2	21052-M-05	Rev. 0	7			
item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	instruction	5	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE INFORMATION RELATIVE TO THIS INSPE ALL SAFETY SIGNIFICANT AND LOW SAI PROCESSES SHALL BE DOCUMENTED O OR FORM 432:43 OR THE DEALINGS.	CTION. FETY CONSEQUENCE WELDING ON FORMS 432,44 AND 432,45	
1.0	General	TPR-6416	Verify 100%	OR FORM 452:45 OR/THE DEALERS. Verity that Freedingline people in the been performed.	•	
2.0	WES Penetrations PIPING	Drawing P-2	Verify 100% Checklist 414,420, Items 1.1, 12, 2.1, 2.2, 2.5, 3.1, 5.1 or 5.2 only	Verify that entry VES/Fabrill enetrations have the approved sealing method (I.E. Vendor day)	XVI DAV. DAV.	
2.1	WES Penetrations FIRE PROTECTION	Drawing FP-4	Verify 100% Checklist 411, 420, items 1.1, 1.2, 2.1, 2.2, 2.5, 3.1, 5.1 on 5.2 only	Verify that any WES Fabric Penetrations had the approved sealing method (i.e., Vehilor day)	W. T.	
2.2	WES Penetrations HVAC	Drawing HV-8 & 7	Verity 100% Checklist 414.A20, Items 1.1, 1.2, 2.1, 2.2, 2.5, 3.1, 5.1 or 5.2 only		ata or FCR/DCN).	
2.3	WES Penetrations ELECTRICIAL	Drawing E-4, 9, 11, 12, 13, 19, 20, 21 8 22	Verify 100% Checklist 414.A20, Items 1.1, 1.2, 2.1, 2.2, 2.5, 3.1, 5.1 or 5.2 only	Verify that any WES Fabric Penetrations have the approved sealing method (I.E. Vendor date)	/ebeen sealed in accordance with ata or FCR/DCN).	

CONSTRUCTION INSPECTION

ANNING PACKAGE

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IP Na.	21052-M-05	Rev. 0			
item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
2.4	WES Penetrations LSS	Drawing LSS-5	Verify 100% Checklist 414.A20, Items 1.1, 1.2, 2.1, 2.2, 2.5, 3.1, 5.1 or 5.2 only		
2.5	WES Penetrations I & C	Drawing IN-13 & 31	Verify 100% Checklist 414.A20, items 1.1, 1.2, 2.1, 2.2, 2.5, 3.1, 5.1 or 5.2 only	Verify that any WES Fabric Penetrations Water been sealed in accordance with the approved sealing method (I.E. Vend by data or FCR/DCN).	
3.0	WES Penetrations	MCP-9110	Verify Random	Verify the ac suspect (doing) at items have been utilized. Record in number:	
4.0	General	MCP-9436 App. A, B & C	Verify Random Checklist 414.A33	Veity that materials, it one are segregated based on quality level, with no co- in righting of quality levels. Record IR number.	
4.1	General	MCP-9436 App. A, B & C And STD-7008	Verify Rapdom Pheckilst 4 4 433	Verify that (speability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number:	
5.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	

INSPECTION PLAN GENERAL NOTES

- IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPTIVELDING SHALL BE DOCUMENTED ON FORM414.09, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY, ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 A N 5 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, WINDER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.W OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABLITY OR CLARIFICATIONOF INSPECTIONS PERFORMED(IE: BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.



age 3 of 3

- 8) NCR/DRINFORMATION HAS BEEN RECORDED PER MCP-538/598.
- 9) ALL BLANKS HAVE BEEN COMPLETEDOR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTSHAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUMTHE FOLLOWING ATTRIBUTES. AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS WALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT/COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS: PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC. ETC.) MAY BE PERFORMEDBY PERSONNEL QUALIFIED A 3 A "GENERAL INSPECTOR".
- 15) CHECKLIST 414,A15 IS BEING PILOTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QEAND THE RE.

	CONSTRUCTION	INSPECTION PLAN	NING PACKAGE	RIGINAL Page 1 of 94
		Final QE Review:	May Stayes	water Date: 5/10/05
WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval:	Ja Jamen	QE: Ron Staymates 10/03/02
Activity/Project Description: OU Floor Structure is safety sign	7-10 Glovebox Excavator Method I fficant (Q2) / WES is low safety co	Facility Structures Insequence (Q3) / RCS	(Q2) is safety significant	Release Date: 10 03 02

P NO. :	21052-M-01	Rev. 3	Clarified attribute 5 1 Nets	on stud welding	
item No.	Process/item/ Material or Equipment	Acceptance criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS.	
1.0	Structural Welding FIELD WELDS ONLY	5060, pg 3 line 25 thru 36	Verify Random	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: 024052-5-025 5-7-03 CELL	12-11-02 CFL
1.1	Structural Welding FIELD WELDS ONLY	5050, pg 4 line 30 thru 37	Verify Random	Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number: 021062-5-025 5-7-3 CEK	12-11-02 CFL
1.2	Structural Welding FIELD WELDS ONLY		Verify Random	Verify that the welding process is being performed in accordance with the parameters defined in the WPS (C-3.5 or 2.11carbon steel, GS 3.04 of 2.7 carbon to stainless steel, S 2.24 stainless or alternate WPS per approved FCR's), including the following:	12-11-02 CEK For C/S Welding ON

IP NO .	21052-M-01	Rev. 3	Ranified attribute 5.1 Nefso	on Stud welding	
ltem No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Camplete Initial/Date
1.2.1	Welding	15060, pg 5 line 11 thru 44 & pg 6 line 1 thru 35	12-11-4	Verify that the welding process is being performed in accordance with the parameters defined in the WPS (C-3.5 or 2.11carbon steel; 98-3.30 or 2.12.40 carbon to stainless steel, \$2.24 stainless or alternate WPS per approved FCR's), including the following: a) base metal preparation 12-11-02-CFR b) cleaning 12-11-02-CFR c) preheat temperature 12-11-02-CFR e) temporary welds 12-11-02-CFR e) temporary welds 12-11-02-CFR g) joint preparation 7-3-CFR Record IR number: 12-10-52-52-52-52-52-52-52-52-52-52-52-52-52-	on s
1.2.2	Structural Welding FIELD WELDS ONLY PER DCN FS-6	5060, pg. 7 line 34 thru 38	TPR-4981, Appendix D Visual 100% Static Loaded HOLD POINT	Visually inspect welds per AWS 11.1. S-025 02/052-M-137 Record IR Number: 02/052-M-137 S-7-03 CER	
1.3	Structural Welding FIELD WELDS ONLY	5060, pg 6 line 37 thru 42 & pg 7 line 1 thru 12	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: 0 240 52-5 0 25	12-11-02 CEK
1.4	Structural Welding FIELD WELDS ONLY	5060, pg 7 line 14 thru 17	Verify Random	Verify that are strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Are strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 0 2-10525-025	CEL CEL
1.5	Structural Welding FIELD WELDS ONLY	5060, pg. 7 line 34 thru 38	TPR-4981, Appendix D Visual 100% Static Loaded HOLD POINT	Visually Inspect welds per AWS D1.1. 8-025 02-1052-74-12-7 Record IR Number: 02-1052-8-025 5-7-03 CER	19-11-02 CEL
2.0	Structural Steel and Misc. Metals Frame	5100, pg 2 line 1 thru 5 & pg 4 line 11 thru 21 and line 35 thru 43 and 13200 pg 2 line 20 thru 36	Verify Random Checklist 414.A15	Verify that the structural steel is erected per the erection plan, manufacturers recommendations and final approved shop drawings. Record IR number: 02 1622M - 006	9-20-02 CER

No.	21052-M-01	Rev. 3	Clarified attribute 5.1 Neis	n Stud welding	
item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
2.1	Structural Steel and Misc. Metal Floor Decking		Verify Random Checklist 414,A15	Verify that the structural steel is erected per the erection plan, manufacturers recommendations and final approved shop drawings. Record IR number: 02.1052-55-025	12-11-0.
2.2	Structural Steel and Misc, Metal		Verify Random Checklist 414.A15	Verify that the structural steel erected per the erection plan, manufacturers recommendations and final approved shop drawings. Record IR number: 02/052-5-025 02/052-5-009 Pp 4/14/03	19-11-01 CFL
2.3	Structural Steel and Misc. Metal Shoring Box		Verify Random Checklist 414_A15	Verify that the structural steel is erected per the erection plan, manufacturers recommendations and final approved shop drawings. Record IR number: NCR-28/3/128/3/1, 28/3/1	CFR
2.4	Structural Steel and Misc. Metal	5100 pg 4 line 26 to 29	Verify Random	Verify that bolted connections have been installed using "snug tight" for all connections except those indicated as moment connections on drawings S-3 and S-4. Record IR number: 02-152-M-06	4-70-01 CFL
2.5	Structural Steal and Misc. Metal	5100 pg 4 line 26 to 29	Verify 100%	Verify that bolted connections have been installed using "twist off type" assemblies for the moment connections indicated on drawings S-3 and S-4. Record IR number: 72-152-14-066 S-02-5	9-20-02 CFL
2.5	Structural Steel and Misc. Metal	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have veen utilized. Record IR number / $24052 - 5-025$	POEK
3.0	Stainless Structural Steel (ref: spec. 5060 criteria listed above)	5101 pg 2 line 31	Verify Random	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number:	O 16 %
3.1	Stainless Structural steel (ref: Spec. 5060 criteria listed above)	5101 pg 2 line 31	Verify Random	Verify that the filler metal is the correct type per the WPS and that it is traceable to an actual CMTR with heat number. Record IR number	DB1/g

1) NO STAINLESS STRUGTPRAL STEEL WENDING PERFORMED for they water 4/8/03 CEL 4-8-03

⊃ No. :	21052-M-01	lev. 3	Clarified attribute 5.1 Nels	on Stud welding.	
item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
3.2	Stainless Structural Steel (ref: Spec. 5060 criteria listed above)	5101 pg 2 line 31	Verify Random	Verify that the welding process is being performed in accordance with the parameters defined in the WPS (S-3.16 stainless or CS-3.04 carbon to stainless), including the following: a) base metal preparation b) cleaning c) preheat temperature d) interpass temperature e) temporary welds f) backing strips/runoff tabs g) joint preparation Record IR number: NA	D 要数
9.3	Stainless Structural Steel (ref; Spec. 5080 criteria listed above)	5101 pg 2 line 31	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs (Record IR number: المراجع	D&Mo
3.4	Stainless Structural Steel (ref: Spec, 5060 criteria listed above)	5101 pg 2 line 31	Verify Random	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in, of base metal shall be removed. Arc strikes exceeding more than 1/32 in, into the base metal shall be considered as a weld defect and repaired as specified. Record IR number:	DPH.
3.5	Stainless Structural Steel (ref: Spec, 5060 criteria listed above)	5101 pg 2 line 31	Visual 100% HOLD POINT Static Loaded	Visually Inspect welds per AWS D1.6 utilizing the attached acceptance criteria section 6.28 (Statically Loaded) Record IR Number: 2/4	OF 19/3
3.6	Stainless Structural Steel	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: N/A	PHONE
4.0	GFE Building Erection WES	13200 pg 2 line 20 thru 36	Verify Random Checklist 414.A15	Verify that the WES structural framing, roof trusses, wind braces, gable roof trusses, doors, louvers, etc. (excluding the fabric cover) is erected per the approved design drawings and manufacturers recommendations. Record IR number: 021052-M-055	1-703 CEL
4.1	GFE Building Erection		100% TPR-4981 Appendix D	Visually inspect field welds utilizing the criteria in items 1.0 thru 1.4 above. Record IR number:	1-7-07
	WES FIELD WELDS	Drawings	HOLD POINT Static Loaded	021052-M-039	المستسا ا

	21052-M-01	1	Clarified attribute 5.1 Nels		
item No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
4.2	GFE Building Erection WES	Universal Fabric Structures Approved Shop Drawings and Manufacturers Criteria	Random	Verity that A-325 bolted connections have been installed using manufacturers recommended criteria. Record IR number 0 2/052 - M - 039	1-7-03 CER
4.3	GFE Building Erection WES	Universal Fabric Structures Approved Shop Drawings and Manufacturers Criteria	Verify Random	Verily that the roof and side wall fabric has been installed per the manufacturers recommended criteria. Record IR number: 021055 - M-039	1-7-0. CEN
4.3.1	GFE Building Erection WES	Universal Fabric Structures Approved Shop Drawings and Manufacturers Criteria	Random	Verify that all seam welding performed in the field is in accordance with the approved manufacturers instructions and the welder is qualified, including the roof, side walls and end walls. Record IR number; 02/055-M,-035	1-7-03 CER
	GFE Building Erection WES	Universal Fabric Structures Approved Shop Drawings and Manufacturers Criteria	Verify Random	Verfiy that the end wail fabric has been installed per the manufacturers recommended criteria. Record IR number: 03-1053-11 -039	1-7-03 CEN
	GFE Building Erection WES	Approved Shop Drawings and Manufacturers Criteria	Random Checklist 414.A15	Verify that the WES tension bars (including sleeves, tabs, tubes, etc.) are installed per the approved design drawings and manufacturers recommendations. Record IR number 0 > 105 - 1105 9	1-7-03 CER
	GFE Building Erection WES	Universal Fabric Structures Approved Shop Drawings and Manufacturers Criteria	Verify 100%	Verify that the WES fabric (roof, side wall and end wall) is free of any tears, rips, or other damage. Record IR number: 02/052-M-039	1-200

No.	21052-M-01	Rev. 3	Clarified attribute 5.1 Nois	on Stud welding, added 7.0	
item No.	Process/Item/ Material or Equipment	Acceptance Chiena Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
4.7	GFE Building Erection	MCP-9110	Verify 100%	Verify that no suspect / counterfeit items have been utilized. Record IR number: 021052-74-039	1-7-03 PER
5.0	GFE Building Erection RCS	13200 pg 2 line 20 thru 36	Verify Random HOLD POINTS a) Start of Erection, b) 50% Erection Completion c) Erection Completion Checklist 414.A15	Verify that the RCS modular panel system (Personnel Monitoring Area, Personnel Access Area, Transfer Vestibule Overburden Area, Emergency Exit Area and the RCS Area) is erected per the approved design drawings and manufacturers recommendations. NOTE: Idaho Professional Engineer must be present at the start of erection, at approximately 50% completion and at completion of construction Record IR number: 0 2 10 52 -5 -040	
5.0.1	GFE Building Erection RCS	13200 pg 2 line 20 thru 36	Verify Random Checklist 414.A15	Verify that the RCS catwalk system is erected per the approved design drawings and manufacturers recommendations. Record IR number: 02/052-5'-040	
5.1	GFE Building Erection RCS	Kelly Klosure Approved Shop Drawings	Visual 100% (welding only) Random (alternate method) HOLD POINT	werity that the floor stud welds (1/2 in., 5% in. and % in.) are completed utilizing approved Nelson Studs, approved Nelson Stud Gun and qualified welders **ACK-29425** Record IR number: 02.1052-5-040 NOTE 1: 3/16 in. Plate may require slotting to allow for installation of the studs to the 7/16 in. Plate. This shall be documented on an approved FCR. NOTE 2: Alternate methods of fastening the RCS to the floor plate may be	1-9-0 CER
5.2	GFE Building Erection	Kelly Klosure Approved Shop Drawings	Verify Random	verify that the Base Gasket has been installed between the floor and the RCS frame. Record IR number: 02/052-5'-040	1-9-0 CER 1-9-0 14-03 CER
5.3	GFE Building Erection	Kelly Klosure Approved Shop Drawings	Verify Random	Verify that the caulk has been installed between the connection joints prior to assembly, when required by erection drawings. (Caulking between connection joints may not be required.) Record IR number:	1=9.0 EER

DNA PER UDR- 34846 RENO R41-21-03

0-43

No.	21052-M-01	Rev. 3	Clarified attribute 5.1 Nek	son Stud welding, added 7.0	
item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
5.4	GFE Building Erection	Kelly Klosure Approved Shop Drawings	Verify Random	Verify that caulk has been installed at all connection joints prior to initial pressure testing. Record IR number: 02/052-5-040	che
5.5	GFE Building Erection RCS	Approved Test Plan	Verify 100% HOLD POINT	Witness initial pressure testing of the RCS. Deleted Per- Document inspection on the test data sheet. FIP 21052-M-1	NA
5.6	GFE Building Erection RCS	Kelly Klosure Approved Shop Drawings	Verify Random	Verify that the tape has been installed over the connection joints after caulking and initial pressure testing. Record IR number: 21052 - M - (2)	N-A
5.7	GFE Building Erection	Kelly Klosure Approved Shop Drawings	Verify Random	Verify that the stainless steel sheet installed on the RCS panels furnished by the supplier is being maintained in a clean condition and shows no evidence of scratches, dings, dents, etc. 02/052-5-040	1-9-03 CER
5.8	GFE Building Erection	Kelly Klosure Approved Shop Drawings and A-5	Verify Random	Verify that the stainless steel sheet has been installed as shown on approved erection drawings by the field with supplier furnished rivets. Record IR number: 2-(2525-040) Verify that A-325 bolled connections (1/2 in. and 5/8 in.) have been installed	1-9-03 CER
5.9	GFE Building Erection	Kelly Klosure Approved Shop Drawings	Verify Random	Verify that A-325 bolted connections (1/2 in. and 5/8 in.) have been installed using "snug tight". Record IR number: 02-1052-51-040	1-9-03 CEK
5.10	GFE Building Erection RCS	Approved Test Plan	Verify 100% HOLD POINT	Witness final pressure testing of the RCS. Document inspection on the test data sheet. Deleted Per Deleted	2 NA
5.11	GFE Building Erection	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: 05-1055-5-040	1-9-03 CEN
6.0	RCS Genera	MCP-9436 App. A, B & C	Verify Random	Verify that materials / items are segregated based on quality level, with no co- mingling of quality levels. Record IR number: 021053-5'-040	CELS

CONSTRUCTION INSPECTION PLANNING PACKAGE

IP No. 2			Clarified attribute 5.1 Nelson Stud welding				
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date		
6.1	,	MCP-9436 App. A, B & C And STD-7006	Verify Random	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferrred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: 02-1052-5-040	1-9-03 CFL		

CIF NUMBER: 21052-M-01 INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL BEASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 21 ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03. "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL RE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL 3E FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE **DOCUMENTED ON FORM 414.04** "VISUAL INSPECTION REPORT" AND ATTACHED **TO** THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.451
- 4) WHEN DOCIMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT MUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE WALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIPATTRIBUTE.
- 61 ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABUTY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 71 M & TE SERIAL NUMBERS AND CALIBRATION DUE RATES HAVE BEEN RECORDED.
- 81 NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538/598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A/D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DAILED.
- 11) VERIFY THAT APPLECABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPUCABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED.
 - A) ANCHOR BOLT PLACEMENT
 - **B)** ANCHOR BOLT TCROUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE. HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A 'GENERAL INSPECTOR".

15) CHECKLIST 414,A15 IS BEING PILOTED IN THIS INSPECTION PLAN (REF. TPR-4921), AND SUBJECT TO CLARIFICATION / REVISION WRING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE.

Page 1 of 4

Final QE Review: Jon Staymen Ber

Date: //- 22-02

WO/SC/PO No. 021052 Requester: Steve Davies Requester Approval: Steve Davies Per QE: Ron Staymates 10/03/02 Per Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility Structures

Stack-Low Sefety Consequence (Q-3)

Requester: Steve Davies Requester Approval: Steve Davies Per QE: Ron Staymates 10/03/02 Per QE: Ron Staymate

IP No.	21052-M-02	Rev. 0	·		
item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
		-		SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS.	
1.0	Structural Welding FIELD WELDS ONLY	5080, pg 3 line 25 thru 36 VDR Number 34820 and 34825 (copy stlached)	Verify Random .	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: 01052-5-015	11-1502 CÉL
1.1	Structural Welding FIELD WELDS ONLY	5060, pg 4 line 30 thru 37 VDR Number 34820 and 34825 (copy attached)	Verify Random	Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number: (1) -1052-5-015	11-15-02 CER
1.2	Structural Welding FIELD WELDS ONLY	5060, pg 5 line 11 thru 44 & pg 6 line 1 thru 35 VDR Number 34820 and 34825 (copy attached)	Verify Random	Verify that the welding process is being performed in accordance with the parameters defined in the WPS (C-3.5 or 2.11carbon steel, CS-3.04 or 2.7 carbon to stainless steel, S 2.24 stainless or alternate WPS per approved FCR's), including the following: a) base metal preparation b) cleaning c) preheat temperature d) interpass temperature e) temporary welds i) backing strips/runoff tabs g) joint preparation Record IR number: () 2-16.52-5-05	11-15-02 26/2 11-15 26/2 11-15 26/2 11-15 26/2 11-15 26/2 11-15 26/2 11-15

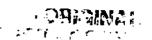


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IP No. 2	21052-M-02	Rev. 0			
item Nō.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.3	Structural Welding FIELD WELDS ONLY	5060, pg 6 line 37 thru 42 & pg 7 line 1 thru 12 VDR Number 34820 and 34025 (copy attached)	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: 02/052-5-0/5 No 1/c/d Record C Required Verify that arc strikes have been ground to a smooth contour but no more than	11-15-02 CER
1.4	Structural Welding FIELD WELDS ONLY	5060, pg 7 line 14 thru 17 VDR Number 34820 and 34825 (copy	Verify Random	1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 02-1052-5-015	11-15-02 CFL
1.5	Structural Welding FIELD WELDS ONLY	5080, PA. 7 line 34 thru 38 VDR Number 34820 and 34825 (copy attached)	TPR-4981, Appendix D Visual 100% Static Loaded HOLD POINT	Visually Inspect welds per AWS D1.1. Record IR Number: 091059-5-015	11-15-02 CEL
2.0	Structural Steel and Misc. Metals	5100, pg 2 line 1 thru 5 & pg 4 line 11 thru 21 and line 35 thru 43 and 13200 pg 2 line 20 thru 36 VDR Number 34820 and 34825 (copy attached)	Verify Random Checklist 414.A15		11-15-02 CEL
2.1	Structural Steel and Misc. Metal	16100 pg 4 line 26 to 29 VDR Number 34820 and 34825 (copy attached)	Verify Random	Verify that bolted connections have been installed using "snug light" for all connections. Record IR number: のメノロリン・トゥーン	11-15-02 CEL

22-0358187 LMIT

CONSTRUCTION INSPECTION PLANNING PACKAGE



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IP No. :	21052-M-02	Rev. 0			
item No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
3.0	Structural Bolts	Drawing C-3	Verify/100%	Verify that the new nuts to be installed to the existing anchor bolts have been approved and are traceable to the vendor data. Defet of Per Record IR number: American Fr. britation Drawith F.I. Verifortial no suspect / counterfeit items have been utilized.	NABA
4.0	Structural Steel and Misc. Metal	MCP-9110	Verify Random	Personal la mangang: .	N-ARIY
6.0	General	MCP-9436 App. A, B & C	Verify Random	Verify Destruction in the second in the seco	N-ARTH
6.1	General	MCP-9436 App. A, B & C And STD-7006		Verify that traceability the kings (QA numbers, hear numbers, etc.) are transferred when material a subdivided, spensive on the unique identifier) Record IR number:	N-A PAY
7.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure (') 2 / (2 - 5 - 0)	11-15 CER

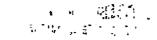
INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPUANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 'VISUAL INSPECTION REPORT' AND ATTACHED TO SHE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43.432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER. LINE NUMBER. ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COW OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABLITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 [698.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR NM'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLEABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, A6 APPLICABLE. PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:

 22-0358188 LMTT

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A) ANCHOR BOLT PLACEMENT B) ANCHOR BOLT TORQUE



- C) LOCATION
- D) ELEVATION
- EI ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC. PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".
- 15) CHECKLIST 414.A15 IS BEING PILOTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURINGM E CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THERE.

		MUSICM-19-0016 14
414.81# 03/08/97 Rev. #01	CONSTRUCTION INSPECTION PLANNING PACKAGE PROVIDENT TO THE PROVING PACKAGE PROVIDENT TO THE PROVINCE OF THE P	BLACK - COPY Males Date: 10/11/02
WC/SC/PO No. 021052 Activity/Project Description: O	Requester: Stave Davies Requester Approval: DAVID STEPHENS / P. U 7-10 Glovebox Excavator Method Mockup Structure (RCS & Shoring Box)	Release Date: 7/14/02

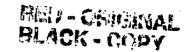
O APPROVED VIA EMALS, DATED 1/10/02 (CARES ANTALMED)

P No.	21052-Mockup-01	Rev. 0	, i		•
item No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION	
1.0	RCS	AWS D 1.1		Visually inspect welds per AWS D1.1. Note: Weld size is to be based on member thickness. Record IR Number: 2/05 2 - 5 - 007	CEL 8
2.0	RCS	AISC	Verify 100%	Verify that boiled connections have been installed using "snug tight" for all connections Record IR number: 21052-5-004 \$ 21052-M-co \$ CEEP	ett 9
3.0	Shoring Box	AWS Drawing 519925 and 519926	100% Kilding	Visually inspect welds per AWS D1.1. Record IR Number: シンクち フ・マーベンフ	8-27-02 CER
4,0	Shoring Box	AISC Drawing 519925 and 519926	Verify 100%	Verify that botted connections have been installed using "turn of the nut" for all ACTM 本328 connections Record iR number: スクちス・5ームッツ	8-27-02
5.0	Materials	MCP-9110	Verify	Verify that no suspect / counterfeit items have been utilized. 0-70 Record IR number: 21052-5-004 21052-11058 CHIL	ELE S

<u>CIP NUMBER: 21052-MOCKUP-01</u> <u>INSPECTION PLAN GENERAL NOTES</u>

- 1) UTILIZE SKETCHES SK-1,4 PAGES TOTAL AND FAX DATED 7/8/02 FROM D.L. STEPHENS TO RON STAYMATES FOR ADDITIONAL INFORMATION RELATED TO THE OVERALL CONFIGUARTION AND MODIFICATIONS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP, INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY AND FORWARDED TO QE FOR REVIEW.
- 3) WHEN DOCUMENTING INSPECTIONS. INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEATNUMER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 4) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABLITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 5) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 6) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 698.

CONSTRUCTION INSPECTION PLANNING PACKAGE



Page 2 of 2

- 7) A U BLANKS HAVE BEEN COMPLETED OR NM'D.
- 8) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 9) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 10) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR'.
- 11] CHECKLIST 414,A15 IS BEING PILOTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE.

APPROVED:

LATE

QUALITY ENGINEER / DATE

REQUESTER DATE

414.811	
09/08/97	
Rev. #01	

WO/SC/PO No. 021052

CONSTRUCTION INSPECTION PLANNING PACKAGE

Final QE Review: Jay Machinetes VD.

Requester: Steve Davies Requester Approval: STEVE DAVIES PER EMAN. QE: Ron Staymates 08/21/02

Activity/Project Description: Receipt inspection of E7018 Weld Rod for the OU 7-10 Glovebox Excavator Method A. 2 Release Date: 8/20/02

IP No.	21052-R-01	Rev. 0	ļ		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.0	Weld Rod	FCR-02-036-05	Verify 100%	Verify that the typical CMTR's have been submitted thru the VDS system and are approved. 1) 262609, 1/8" E7018, QA-93317 2) 252691 3/32" E7018, QA-93318 3) 222696, 3/32" E7018, QA-93318	8-2702 CEA
2.0	Weld Rod	FCR-02-036-05	Visual TPR-6416 100%	Perform receipt inspection and re-tag material containers for lot 262609, 1/8°, E7018, QA-93317 at CPP-698 warehouse as Q2. Recent quantity inspected: P\$ 8-15-03	3-27-02 CER
3.0	Weld Rod	FCR-02-036-05	Visual TPR-6416 100%	Perform receipt inspection and re-tag material containers for lot 252691 3/32* E7018, QA-93318 at CPP-698 warehouse as Q2. Record quantity inspected: R\$ 8-15-03	8-2702 CER
4.0	Weld Rod	FCR-02-036-05	Visual TPR-6416 100%	Perform receipt inspection and re-tag material containers for lot 222696, 3/32* E7018, QA-93318 at CPP-698 warehouse as Q2. Record quantity inspected: // 8 -/5 - 03	8-27-02 CER

CIP NUMBER 21052-R-01 INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO RE UNSATISFACTORY (IV) THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PIAN REQUIREMENTS.
- 2) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION/ ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 3) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 4) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 5) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 6) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 7) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110,
- 8) ALL ATTRIBUTES IN THIS PIAN. EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A 'GENERAL INSPECTOR'.

021052-R-01 7 Rg. 2 of 2 81

Steven A Davies

08/21/02 12:32 PM

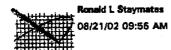
To: Ronald L Staymates/STAYRL/CC01/INEEL/US@INEL cc: Curtis E Reay/CR6/LMITCO/INEEL/US@INEL, Darin R Johnson/JOHNDR/CC01/INEEL/US@INEL, David S Behrens/DSB/CC01/INEEL/US@INEL, J S Stone/JSTONE/CC01/INEEL/US@INEL

Fax to:

Subject: Re: PIT-9 Weld Rod Upgrade

inspection Plan is Approved.

Ronald L Staymates



To: Steven A Davies/SDV/CC01/INEEL/US@INEL, David S Behrens/DSB/CC01/INEEL/US@INEL, Darin R Johnson/JOHNDR/CC01/INEEL/US@INEL

cc: J S Stone/JSTONE/CC01/INEEL/US@INEL, Curtis E Resy/CR6/LMITCO/INEEL/US@INEL

Fax to:

Subject: PIT-9 weld Rod Upgrade

Attached are the revised FCR and Inspection Plan for your review.

The following actions need to happen:

- 1] FCR needs to be processed, if found to be acceptable.
- 21 FCR number needs to be smalled to me for incorporation into the inspection plan.
- 3) Steve Davies needs to email me approval of the inspection plan, ifacceptable. I will add the FCR number to the plan upon receipt of this information.
- 41 The CMTR's need to be placed into the VDS system for review and approval. I have the copies for this action to be completed.
- 5) The CMTR's need to be approved prior to performing the inspection
- 6) I will forward an electronic copy of the inspection plan to Curtis Reay for completion. Then I will mail the hard copy for his signature.
- 7) Curtis Reay will perform the inspection an\$ re-tag the material using the electronic copy. The hardcopy will then be completed by Curtis Reay upon receipt. Curtis will then return the completed inspection plan to me for final review and closure.

Ron Staymates
ConstructionQA
Phone 6-3584 / Fax 6-2947 / WCB MS 3535
Email: stayri

414.81#	
09/08/97	
Rev. #0	١

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Page 1 of

Final QE Review:

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4-30-03

WO/SC/PO No. S00-021052 Requester: S Davies Requester Approval: Control of the Co

		Flev. 3	Rev. 3 Provided further of Mechanical. Added separ	larification on items to be receipt inspected. Added couplings, pipe nipples and pipe plugs to tete line items for each type of material.	Atlas
	,	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
N/A	N/A	N/A	N/A	Subcontractor material that is safety class (Q-1), safety significant (Q-2) or law safety consequence (Q-3) requires receipt inspection. This includes the following items, as a minimum: (see Form 414.02 & 414.70 for details) 1) Inspector shall record the following information on the inspection Report: A) Item description B) VDS item number, a sapplicable C) Quantity inspected D) Serial numbers/unique identifying numbers	TVA
1.0	S/S Ductwork (Atlas Mechanical)	PR-6416	Visual / 100%	Verify the following conditions, as applicable 1) Damage 2) Cleanliness 3) protective coating 4) markings / identification 5) dimensional (random) – utilize approved fab drawings, catalogue cuts, etc. 6) surface condition / finish 7) weld appearance 8) end protection 9) end preparation 10) storage level & segregation per MCP-9436 (this is not an accept/reject attribute. If material is not being segregated, document on an IR and forward the IR to the QE) IIR number: 23/252-11-91-9	16 1.3-07
1.1	PerVDS	TPR-6416	Visual / 100%	Verify that the material is traceable to the associated documentation, and that it complies with the approved vendor data. IR number: \$\tilde{2}\left(\sigma \frac{7}{2} \cdot \frac{7}{2} \cd	11.5-=-



IP No. 2	21052-R-02	Rev. 3		arification on items to be receipt inspected. Added couplings, pipe nipples and pipe plugs to ate line items for each type of material.) Atlas
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Data
1.2	Per Form 414.02 and / or 414.70	TPR-6416	*	Apply a QC Accept tag to the items, where practical. When this is not feasible, the tag shall be placed with the inspection report for future reference. NOTE: All items accepted shall be uniquely identified to indicate acceptance. This identification shall consist of either placing a tag, where possible or by applying the QA number and initial/date physically on the item with a black indelible marker.	11-5-12

414.81# 09/38/\$7 Rev. #01

No. 1		Rev. 3	Mechanical, Added secar	arification on items to be receipt inspected. Added couplings, pipe ripples and pipe plugs to ale line items for each type of material	T
tem No.	Frocess/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complet Initial/Dat
2.0 A) RCS & Glevebox bulkhead fittings * Ref: CGI form for p/n W3ZA5, dated 12/3/02 B) Couplings*	TPR- 6 416	Visual / 100%	Verify the following conditions, as applicable 1) Damage 2) Cleanliness 3) protective coating 4) markings / identification 5) dimensional (random) – utilize approved tab drawings catalogue cuts, etc.	12-3-02	
	Ref: CGI form for DWG 522717,	TPR-6416	Visual / 100%	6) surface condition / finish 7) weld appearance 8) end protection 9) end preparation 10) storage level & segregation per MCP-9436 (this is not an accept/reject attribute. If material is not being segregated, document on on IR and forward the IR to tha QE)	K6 12-5-2
	C) Pipe plugs* . Ref: CGI form for DWG 622717, dated 12/3/02	TPR-6416	Visual / 100%	IR number: ♠ 11851- V- ◆41	13.500 m
	D) Motorized Damper* Ref: CGI form for Spec. 15801 & DWG 522712, dated 12/12/02	TPR-6416	Visual / 100%		.च्या कर [्]
	E) Flanges*	TPR-0416	Visual / 100%	Fabricated In-House, No CGI form Required	NVA
	F) Bolts/Nuts* Ref: CGI form for Spec. 15801, dated 12/11/02	TPR-6416	"isual / 100%		12502
		,			

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⊃ No. 2	21052-R-02	lev. 3	lev. 3 Provided further cla	urification on items to be receipt inspected. Added couplings, pipe nipples and pipe plugs to te line items for each type of material.	Atias
item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
	G) Gaskets* Ref: CGI form for Spec. 15801, dated 12/11/02	'PA-6416	'isual / 100%		12-16-02
	Mechanical)				
2.1	Mechanical		" 1,4000,4		(1)
		'PR-6416	/isual / 100%	'erify that the material is traceable to the associated documentation, and that it omplies with the approved vendor data. R number: **Description** Particular Particular	-11-09
2.2	Per Form 431.53 & FCR-13223-2C	ICP-3772/ PR-6416	'erify / 100%	'erform inspections specified on the CGI Form 431.53, for the items identified rith an • and attach to this plan. Document inspections on an IR Form 414.03. lecord IR numbers: 210072-1-021	-21-03
2.3	Per Form 414.02 and / or 414 70	'PR-6416	rerify / 100° o	pply a QC Accept tag to the items. where practical. When this is not feasible. ne rag shall be placed with the inspection report for future reference. IOTE: All items accepted shall be uniquely identified to indicate acceptance. his identification shall consist of either placing a tag. where possible or by pplying the QA number and initial/date physically on the item with a black idelible marker.	-21-07
3 0	A) RCS Bulkhead Fittings • Ref: CGI form f o p/n WBZA5, dated 12/3/02 (DCNFP-10) (3D Fire Protection)	'PR-6416	′isual / 100%	'erify the following conditions, as applicable 11) Damage 12) Cleanliness 13) protective coaling 14) markings / identitication 15) dimensional (random) – utilize approved fab drawings, Catalogue cuts, etc. 16) surface condition / finish 17) weld appearance 18) end protection 19) end preparation 20) storage level & segregation per MCP-9436 (this is not an accept/reject attribute. If material is not being segregated, document on an IR and forward the IR to the QE) 3 number: • 1 10 5 2 10 10 10 10 10 10 10 10 10 10 10 10 10	1.5.02
3.1	Per VDS	'PR-6416	'isual / 100%	'erify that the material is traceable to the associated documentation, and that it omplies with the approved vendor data. 3 number: **1.053-V-35** ** \$21053-V-019** **P141.1	-Tr-03

P\$ 4/30/03

414.81# 09/08/97 Play. #01



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	T 73	<u></u>	INBURANCAL POURO SEDE	rate line items for each type of materia.	1
item No.	Process/Item/ Material or Equipment	Acceutance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
3.2	Per Form 431.53 & FCR-13223-20		Verify / 100%	Perform inspections specified or the CGI Form 431.53, for the items identified with an * and attach to this plan. Document inspections on an IR Form 414.03. Record IR numbers: معرفة على المحرفة على المحرفة على المحرفة ال	2-18-03
3.3	Per Form 414.32 and / or 414.70	TPR-6416	Verify / 100%	Apply a QC Accept teg to the items, where practical. When this is not feasible, the tag shall be placed with the inspection report or future reference. NOTE: All items accepted shall be uniquely identified to indicate acceptance. This identification shall consist of either placing a tag, where possible or by applying the QA number and initial/date physically on the item with a black indealing market.	1.19.03 2.19.03
4.0	Weld Rod (Continental Steel)	TPR-6416	Visual ! 100%	Verity the following conditions, as applicable 1) Damage 2) Cleanliness CER 4-2/-3 3) protective coating CER 4-2/-3 4) markings / identification CER 4-2/-3 5) storage level & segregation per MCP-9436 (this is not an accept/reject attribute. If material is not being secregated, document on an IF and forward the IR to the QE) IR number:	4 ER
4.1	Per VDS	TPR-6416	Visual / 100%	Verify that the material is traceable to the associated documentation, and that it complies with the approved vendor data.	4-21-0 CER
4.2	Per Form 414.02 ਬਾਜ਼ੀ/ਗ 414.70	TPR-6416	Verify / 100%	Apply a QC Accept tag to the items, where practical, When this is not feasible, the tag shall be placed with the inspection report for future reference. NOTE: All items accepted shall be uniquely identified to indicate acceptance. This identification shall consist of either placing a tag, where possible or by applying the QA number and initial/date physically on the item with a black indelible marker.	4-21-0 CER
5.0	Weid Rod (Warbonnet Electric)	TPR-6416	Visual ∤ 100%	Verify the following conditions, as applicable 1) Damage 2) Cleanliness AU WEWING PERFORMED 3) protective coating By ATLAS—SEE ATLAS 4) markings / identification WELD MAPS PA 1/24/63 5) storage level & segregation per MCP-9436 (this is not an accept reject atribute. If material is not being segregated, document on an IR and forward the IR to the OE) IR number:	N-A

CONSTRUCTION INSPECTION PLANNING PACKAGE



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		Rev. 3	lev. 3 Provided further day	arification on items to be receipt inspected. Added couplings, pipe nipples and pips plugs to ate line items for each type of material.	Atlas
ltem No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
5.1	PerVDS	PR-6416	fisual / 100%	/erify that the material is traceable to the associated documentation, d that it complies with the approved vendor data. R number:	N-4
5.2	Per Form 414.02 and / or 414.70	'PR-6416	/erify / 100%	Apply a QC Accept tag to the items, where practical. When this is not feasible, he tag shall be placed with the inspection report for future reference. ***ACTE: All items accepted shall be uniquely identified to indicate acceptance. This identification shall consist of either placing a tag, where possible or by applying the QA number and initial/date physically on the item with a black idelible marker.	N-A
6.0	Weld Rod (Atlas Yechanical)	PR-6416	risual / 100%	lerify the following conditions, as applicable 1) Damage 2) Cleanliness 3) protective coating 4) markings / identification 5) storage level & segregation per MCP-9435 (this is not an accept/reject attribute. If materia [is not being segregated, document on an IR and forward the IR to the QE) R number: \$2052-808	r- 12. 05
6.1	Per VDS	TPR-6416	'isual / 100%	/erify that the material is Iraceable to the associated documentation, and that it omplies with the approved vendor data. R number: • 11052-11-01/	11-5-02
6.2	Per Form 414.02 and / or 414.70	TPR-6416	'erity / 100%	a QC Accept tag to the <i>items</i> , where practical. When this is not feasible, he tag shall be placed with the inspection report far future reference. IOTE: All items accepted shall be uniquely identified to indicate acceptance. his identification shall consist of either placing a tag, where possible or by polying the QA number and initial/date physically on the item with a black idelible marker.	11-5-00

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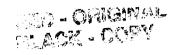
o.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
.0	Criticality Alarm System Components A) Light Poles* Fef: OGI form for CWGs 522664 & 522665, dated 10/3:/02	TPR- 6 416	Visual / 100% Visual / 100%	Verify tile following conditions, as applicable I) Darnage 2) Cleaniness 3) protective coating 4) markings (identification 5) dimensional (random) = utilize approved fab drawings, catalogue cuts, etc. 6) surface condition / firish 7) weld appearance	A.) ************************************
	R) Self tapping screws* Fet: CGI torm for CWGs 522654 & 522665, dated 10/3*/02	TPR-6416	Visual/ 100%	8) end protection 9) end preparation 10) storage level & segregation per MCP-9436 [this is not an accept/reject attribute. If material is not being segregated, document on an IR and forward the IR to the QE. IR number: こえノロラン・テンスフ	AJA SEE ROSZ-R- REPORT B MAR J4-2 CADSCREE RB YZYJO
	C) Conduit & Connectors* Ref: CGI form for SPC-389, 18610- 2, dated 10/15/02	TPR-6416	Visual / 100%		TWC.

118.514 76/80/60 104 .veH

Et to 8 ege9

Eoles/4 29 Eoles/4 20 Eoles/4 20 Eoles/			%001 \ lsueiV	8148-R9T 8148-R9T	cismps & Caraps* CGI form for CGI form for CGI to CGI form for CGI care 11/25/02	
E0/42/4 \$ 2	125 125				cismps & control form for CGI form for CGI form for CGI date 11/25/02 CBI Channel & CB	
Enfezire Secso-3-250120 XI	** \$		%001 \ leusiV	91+3-A9T	stamps & stants staps. not mot lad	
EO/KZ/h Pd			29001 \ JeusiV	ana.egr	1inbao2 (3	
6~1" */ //1				· ·	CGI form for DWG 522770, dated 11/25/02	
(3 50/3//2			%001 \ IsuaiV	8 1 48-유역T		
(7 280-2-250 120)20 2 240-3-250 120)20	· ·				10/15/02 and CGI form for DWG 522770, Caste Columbia Colu	
50/12/1 m	, · , ·				Ref:CGI form fort SPC-389, 161 10- 2, line 25, dated	
eiseUvaitini (\(\Omega \cdot \cdot -3-s2 \cdot size \cdot X \cdot \cdo	Instructions	: •	Method/Procedure Reference Menal / 100%	eonateooA sinefinO eonerateR 8146-A9T	Process/liem/ Material or Equipment Equipment (0) Cable & wire*	mei No.

CONSTRUCTION INSPECTION PLANNING PACKAGE



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P No.	P No. 21052-R-02 Rev. 3		Rev. S Provided further cl Mechanical. Added separ	rided turther clarification on item to be receipt inspected. Added couplings, plpe nipples and pipe plug: . Added senarate line <u>items for each type of material</u> .		
Item	Material or Criteria Equipment Reference		Method/Procedure Reference	Instructions	Complete Initial/Date	
	H) Junction boxes & covers* CGI form for DWG 522770, dated 11/25/02 (Warbonnet Electric)	TPA-6416	Visual / 100%		N/A zelos	
7.1	Per VDS	TPR-6416	Visual / 100%	Verify that the material is traceable to the associated documentation, and that it complies with the approved vendor data. IR number: 02/052-5-057	W4/17/0:	
7.2	Per Form 431.53 & FCR-13223-20		Verity / 100%	Perform inspections specified on the CGI Form 431.53, for the items identified with an * and attach to this plan. Document inspections on an IR Form 414.03. Record IR numbers: p2,052-8-057	Mylmlos	
7.3	Per Form 414 02 arid / or 414.70	T'PR-6416	Verity / 100%	Apply a QC Accept tag to the items, where practical. When this is not feasible, the tag shall be placed with the inspection report for future reference. NOTE: All items accepted shall be uniquely identified to indicate acceptance. This identification shall consist of either placing a tag, where possible or by applying the QA number and initial/date physically on the item with a black indelible marker. 22/052-5-05-7	not ylulas	

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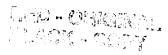
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IP No. 3	21052-R-02	Rev. 3	Rev. 3 Provided further cl Mechanical_Added_separ	arification on items to be receiptinspected. Added couplings, pipe nipples and pipe plugs to ate line items for each type of material.	Atlas
item No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
8.0	A) Criticality Detector Cluster Frame	TPR-6416	Visual I 100%	(V) Conditions, as applicable (I) Conditions, as applicable 2) Cleanliness (I) protective coating	(h) 01-02-03
	B) Criticality Console Housing Frame	TPR-6416	Visual / 100%) rn ig / fit ii) dimensional (random) — li api ii fab drawii cuts,	K\$ 02-03
	C) Light/Alarm Pale Supports	TPR-6416	Visual / 100%	") weld appearance i) end for i) end preparation	162.03
	D) Criticality Alarm Supports	TPR-6416	Visual / 100%	t 1 g 1 & ic pe M 136 ftf is not; ie : 1 tta tf material is it sin l, if on it tR d the tR to the QE)	1-02-03
	E) Self tapping screws* Ref: CGI form for DWGs 522664 and 522665, dated 10/31/02	TPR-6416	Visual / 100%	IR number: 321051-1-4-3	1-02-03
	F) Pipe Nipple* Ref: CG I form for DWGs 522664 and 522665, dated 10/31/02	TPR-6416	Visual / 100%		1-02-03
	G) Pipe Sleeve' Ref: CGI form for DWGs 522664 and 522665, dated 10/31/02	TPR-6416	Visual / 100%		1-03-03



	2L052-R-02	Rev. 3	Mechanical. Added separ	arification on items to be receipt inspected. Added couplings, pipe nipples and pipe ato line items for each type of material.	plugs to Alias
ltem No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
	H) Socket head cap screws* Ref: CGI form for DWGs 522864 and 522665, dated 10/31/02		Visual / 100%		217-03
	grade 8 bolts'	MCP-3772, rev. 5 4.1 Note {copy attached}	Verity 100%	Verify manufacturers markings per ASTM/ASME Specification	3-17-03
	núts*	MCP-3772, rev. 5 4.1 Note (copyattached)	Verify 100%	Verify manufacturers markings par ASTM/ASME Specification	2-13-03 KB 2-13-03
	washers'	MCP-3772. rev. 5 4.1 Note (copy attached)	Verify 1 <i>00</i> %	Verify manufacturers markings per ASTM/ASME Specification	2-19-49
	L) Split Ring Lock Washers* Ref: CGI form for DWGs 522864 and 522665, dated 10/31/02	TPR-6416	Visual / 100%		2-17-13
	{Reference: FCR-13233-20, 13233-26 & DCN FP-19)				2.17.03
	(Steel Wast)				

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IP No.	21052-R-02	Rev. 3		arification on items to be receipt inspected. Added couplings, pipe nipples and pipe plugs to ate line items for each type of material.	Atlas
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
8.1	PerVDS	TPR-6416	Visual / 100%	IR number: 2/051 - 2-4754	2.12-47
8.2	Per Form 431.53 & FCR-13223-20		Verify / 100%	Perform inspections specified on the CGI Form 431.53, for the items identified with an * and attach to this plan. Document inspections on an IR Form 414.03. Record IR numbers: 2/057-L. L. T. M. L. C.	1-17-03
8.3	Per Form 414.02 and / or 414.70	TPR-6416	Verify / 100%	Apply a QC Accept tag to the items, where practical. When this is not feasible, the tag shall be placed with the inspection report for future reference. NOTE: All items accepted shall be uniquely identified to indicate acceptance. This identification shall consist of either placing a tag, where possible or by applying the QA number and initial/date physically on the item with a black indelible marker.	ић 18 3-17-03
9.0	Inspection Plan	MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	4-24-03

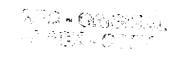
INSPECTION PLANGENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, 'QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTSTHAT WILL PROVIDE TRACEABLITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCHTICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATIONHAS BEEN RECORDED PER MCP-538/598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OF NIA'D.
- 10) WHEN PERFORMING LIQUID PENETRANT EXAMINATION RECORD THE BATCH NUMBERS ON EITHER THE WELD HISTORY RECORD OR THE IR OR

THE CIP.

414 R1# 60/08/07 Rev. #C1

CONSTRUCTION INSPECTION PLANNING PACKAGE



Page 13 of 13

- 1') ALL LINE CUTS OR WRITE OVERS HAVE BEEN INITIALEDAND DATED.
- 12) VERIFY THAT APPLICABLE VDS DUCUMENTS HAVE BEEN APPHOVED UH SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 13) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUMTHE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE COUPMENT BOING INSPECTED:
 - A) ANCHOR BOLTPLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 14) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT/COUNTERFEIT ITEMS PER MCP-8110.
- 15) ALL ATTRIBUTES INTHIS PLAN EXCEPT THOSE THAT REQUIRE A SPECIFIC QUAL FICATION, (LE WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETG.) MAY BE PERFORMED BY QUALIFIED PERSONNEL CTHER THAN A "GENERAL INSPECTOR".
- f6) WHEN CONFLICTS ARISE THAT PRECLUDE THE INSPECTOR FROM PERFORMING A VERIFICATION ACTIVITY. THE INSPECTOR IS ALLOWED TO DOCUMENT COMPLETION OF INSPECTION STEPS, DASED ON ODJECTIVE EVIDENCE FROM THE COGIZANT STR OR GETHAT THOSE STEPS HAVE BEEN DOMPLETED AS DESCRIBED IN THE INSPECTION PLAN. ATTACH COPIES OF THE ORIFICTIVE FVIDENCE TO THIS PLAN.

414.81#
09/06/97
Rev. #01

Page 1 c

Final QE Review:

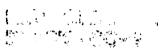
Ly Stanister

Date: 4/21/03

WO/SC/PO No. S00-021052 Requester; 8 Davies Requester Approval: Tom HIPP FEL PARK QE: Ron Staymales Park Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility Package Receipt Inspection Activities (CAS Control Enclosure)

P No. 2	21052- F1-03	Rev. 0	ļ.	,	
item No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
N/A	N/A	N/A	N/A	Subcontractor material that is safety class (Q-1), safety significant (Q-2) or low safety consequence (Q-3) requires receipt inspection. This includes the following items, as a minimum: (see Form 414.02 & 414.70 for details) 1) inspector shall record the following information on the inspection Report: A) item description B) VDS item number, as applicable C) Quantity inspected D) Serial numbers/unique identifying numbers	N/A
1.0	CAS Control Enclosure (Warbonnet Electrical) Ref. Pun FP-18 Ref. refores	TPR-8416	Visual / 100%	Verify the following conditions, as applicable 1) Damage 2) Cleanliness 3) protective coating 4) markings / identification 5) dimensional (random) – utilize approved fab drawings, catalogue cuts, etc. 6) surface condition / finish 7) weld appearance 6) end protection 9) end preparation 10) storage level & segregation per MCP-9436 (this is not an accept/reject attribute. If material is not being segregated, document on an IR and forward the IR to the QE) IR number: 02105⊋- €-09€	And 3
1.1	Per VDS	TPR-6416	Visual / 100%	Verify that the material is traceable to the associated documentation, and that it complies with the approved vendor data. IR number: $0.21052-E-0.7$ C	3-4-0

CONSTRUCTION INSPECTION PLANNING PACKAGE



Page 2 of 3

			_ ,		
IP No.	21052-R-03	Rev. 0	7.	•	
ltem No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.2	Per Form 431.53 For Drawing 522776, dated 12/18/02	MCP-3772 / TPR-8416	Verify / 100%	Perform inspections specified on the CGI Form 431.53, for the items identified with an * and attach to this plan. Document inspections on an IR Form 414.03. . Ab/c '988 Charce Number #/50 Ab 3.4-3 Record IR numbers: 021052-E-096 SEE CRIOSE-E-095 RECEIPT INSPECTION ALSO PS #2/63	3-4-03
1.3	Per Form 414.02 and / or 414.70	TPR-6416	Verify / 100%	Apply a QC Accept tag to the items, where practical. When this is not feasible, the tag shall be placed with the inspection report for future reference. NOTE: All items accepted shall be uniquely identified to indicate acceptance. This identification shall consist of either placing a tag, where possible or by applying the QA number and initial/date physically on the item with a black indelible marker.	MS,4.03
2.0	Inspection Plan	MCP-2482	Vərify	Verify that all inspections have been completed and forward this inspection plan	m50)

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS A CHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPTWELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY, ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, UNE NUMBER, ROOM NUMBER ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION /ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 114.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABLITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M& TE SERIAL NUMBERSAND CALIBRATION W E DATESHAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKSHAVE BEEN COMPLETED OR WA'D.
- 10) WHEN PERFORMING LIQUID PENETRANT EXAMINATION RECORD THE BATCH NUMBERSON EITHER THE WELD HISTORY RECORD OR THE IRLOR
 - THE CIP.

N. .

- 11) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 12) VERIFY THAT APPUCABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.

22-0357459 LMIT



- 19) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED.
 - AL ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) UNIENTATION
- 14) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT ITEMS PER MCP-911U.
- 15) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY QUALIFIED PERSONNEL OTHER THAN A "GENERAL INSPECTOR".
- 16) WHEN CONFLICTS ARISE THAT PRECLUDE THE INSPECTOR FROM PERFORMING A VERIFICATION ACTIVITY, THE INSPECTOR IS ALLOWED TO DOCUMENT COMPLETION OF INSPECTION STEPS, BASED ON OBJECTIVE EVIDENCE FROM THE COGIZANT STR OR OF THAT THOSE STEPS HAVE BEEN COMPLETED AS DESCRIBED IN THE INSPECTION PLAN. ATTACH COPIES OF THE OBJECTIVE FVIDENCE TO THIS PLAN.

Page 1 of 4

Release Date: 14/27/2-

QE: Ron Staymates 10/21/02

CONSTRUCTION INSPECTION PLANNING PACKAGE

Rev. #01 46/B0/60 #18.414

WO/SC/PO No. 021052

E9-12-1

Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility Installation Package Rednester Approval: 572VE 29VVES 1200 Requester: Steve Davies Final QE Review:

ç∘-1 ^{₹-1} 9 <i>‡</i>	verify that the welding process is being performed in accordance with the satisfied metal preparation 3) base metal preparation 3) cleaning 3) preheat temperature 4) interpass temperature 3) interpass temperature 3) preheat temperature 4) interpass temperature 3) joint preparation 3ecord IR number: OLIOSIL-5-137	\enify 00%	9060, pg 5 inne 11 ולהט 44 & pg 11 inne 1 להט 12 inne 1 להט	Structural Welding CRITICALITY DETECTOR CLUSTER FRAME	7.1
60-1T-1	Verity that the filler metal is the correct type per the WPS and that it is traceable to an actual CMTR. (هـ الهـ الهـ الهـ الهـ الهـ الهـ الهـ ا	Fc001	5060. pg 4 line 75 undi 05	CLUSTER FRANE Studing Welding CRITICALITY DETECTOR OETECTOR TOURSTER	÷ :
£0.11.1	INFORMATION RELATIVE TO THIS INSPECTION. ALL WELDING PROCESSES SHALL BE DOCUMENTED. Verify that the welders are qualified to perform the welding process and have a current qualification. **No St. **Long St.	Venfy 1003∻	9060. pg 3 line SS und 35	INSPECTIONS Structural Welding CRITICALITY CRITICALITY	0.1
Complete Initial/Date	Instructions see FOR ADDITIONAL	Method/Procedure Reference	Acceptance Criteria Reference	Process/Item/ Material or Equipment	Item No.
			Rev. 0	20-2-2012	.on qı

IP No.	21052-S-02	Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	instructions	Complete Initial/Date
1.3	Structural Welding CRITICALITY DETECTOR CLUSTER FRAME	5060	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number:	الا
1.4	Structural Welding CRITICALITY DETECTOR CLUSTER FRAME	5060	Verify 100%	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as	√6 ₁-21-03
1 I	Structural Welding CRITICALITY DETECTOR CLUSTER FRALIE	5000 and Approved Shop Drawines	TPR-4981, Appendix D √isual Random (20 / minimum) Static Loaded HOLD POINT	Visually inspect welds per AWS D1.1893 Record IR Number: 03051-5-137 NOTE: In-house inspections shall be documented by the Steel West Inspector per the approved vendor data	1-21-03
1	Structural Steel CRITICALITY DETECTOR CLUSTER FRAME	Approved Shop Drawings	√enfy Random	that the dimensions shown on the shop the shop drawings are in coloniance with the shop drawings are in tolerances indicated Re d IR number	LB 1-03
3.0	Structural Steel and Misc. Metal CRITICALITY DETECTOR CLUSTER FRAME	MCP-9110	/erify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: 03/053-5-/37	LB 1-21-03
	General CRITICALITY DETECTOR CLUSTER FRAME	иСР-9436 ∖рр. А , В & С	lerify Random	Verify that materials / items are segregated based on quality level, with no comingling of quality levels. Record IR number:	KB 1-21-03

IP No. 2	21052-S-02	Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	MethodlProcedure Reference	Instructions	Complete Initial/Date
4.1		IMCP-9436 & STD-7006	Verify 100%	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number:	/b /-15-03
4.2	General CRITICALITY DETECTOR CLUSTER FRAME	MCP-9436	Verify 100%	Verfiy that the material is traceable to the approved documentation (CMTR's, P.O's, etc.) Record IR number —: ——————————————————————————————————	KI 1-23-03
5.0		MCP-2482	√erify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	do

CONSTRUCTION INSPECTION PLANNING PACKAGE

ISSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
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- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABLITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7: M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCB DR INFORMATION HAS BEEN RECORDED PER MCP-538 598.
- 9. ALL BLANKS HAVE BEEN COMPLETED OR N A'D.
- 10 ALL LINE OUTS OR \?'RITE OVERS HAVE BEEN INITIALED AND DATED.
- TI MERIEN THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED. AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- TO DISTAILATION INSPECTIONS SHALL INCLUDE AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - AL ANCHOR BOLT PLACEMENT
 - B. ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E: ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT, COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".

CONSTRUCTION INSPECT. A PLANNING PACKAGE

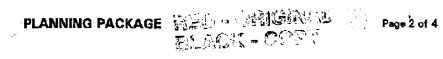
%18.414 76/80/90 10% ,vmA

Final GE Review: Date:

Release Date: 19/2-162	292461 114HB	0 Glovebox Excavator Method Facility installation Package	Activity/Project Description: OU 7-1
QE: Ron Staymates 10/21/02	DE BUNES DEC	Requester: Stove Davies Requester Approval: 572	WO/SCIPO No. 021052

Complete 5	enoliouseni	Method/Procedure esnerence	Rev. 0 Acceptance Criteria	1052-5-03 Process/item/ Material or	llem No.
	SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION.		aprenetaR	Edulpment Edulpment	
	ALL WELDING PROCESSES SHALL BE DOCUMENTED.		• .		
\$ • -1 E -1	Verify that the welders are qualified to perform the welding process and have a current qualification.	ሃቀተለ 100%	5060, pg 3 line 25 thru 36	Structural Welding	
	ዱዮራ-ቕ-ፍፋቀነፍ ል nadmun Al broseA		,	CRITICALITY CONSOLE HOUSING HARME	
استاد-ه ع الري	Verify line filer metal is the correct type per the WPS and that if is traceable to an actual CMTR. Record iR number a داهاء حاماته الله الله الله الله الله الله الله ا	Verity 100%	5060; pg 4 line 30 thu 37	Structural Welding Welding	ı'ı.
go-18-1 971	Verify that the welding process is being performed in accordance with the parameters defined in the approved WPS, including the following: a) base metal preparation b) cleening c) preheat temperature d) interpase temperature e) temporary welds e) temporary welds	Vaniy 100%	6060, pg 5 أأنه 11 ثانت 44 هـ pg 5 ثانت 1 ثانت 55	FRAME Structural Welding CRITICALITY CONSOLE HOUSING HOUSING	ا.2
	(1) paciding stripsylving (1898) Joint preparation (3) Joint preparation (4) Baciding stripsylving (1898)				

CONSTRUCTION INSPEC.



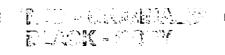
P No.	21052-8-03	Rev. 0			
llem No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	instructions	Complete Initial/Date
1.3	Structural Welding CRITICALITY CONSOLE HOUSING FRAME	5060	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: ************************************	المار 3ددر
1.4	Structural Welding CRITICALITY CONSOLE HOUSING FRAME	5080	Verify 100% -	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. Into the base metal shall be considered as a well defect and repaired as specified. Record IR number: a 2/+53-5-45	16 1-21-03
1.5	Structural Welding CRITICALITY CONSOLE HOUSING FRAME	5060 and Approved Shop Drawings	TPR-4981, Appendix D Visual Random (20% minimum) Static Loaded HOLD POINT	Visually Inspect welds per AWS D1.1. Record IR Number: • 2.1 • 51-1 • 045 NOTE: In-house inspections shall be documented by the Steel West Inspector per the approved vendor data.	18
2.0	Structural Steel CRITICALITY CONSOLE HOUSING FRAME	Approved Shop Drawings	Verify / Random	Verify that the dimensions shown on the shop the shop drawings are in conformance with the shop drawings and tolerances indicated. Record IR number: ੦೭/੦±೭-៩- ੦੫ਰੀ	1-21-03
3.0	Structural Steel and Misc. Metal CRITICALITY CONSOLE HOUSING FRAME	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: ອ ລາ ຈະລະສະວະເລີ	1-21-03
4.0	General CRITICALITY CONSOLE HOUSING FRAME	MCP-9438 App. A, B & C	Verify Random	Verify that materials / Items are segregated based on quality level, with no co- mingling of quality levels. Record IR number: * 1パッタコーターのが	1-21-03



Page 3 of 4

IP No. :	21052-S-03	Rev. 0				
Item No.	Process/item/ Material or Equipment	Acceptance Criteria Reference		od/Procedure eference	Instructions	Complete Initial/Date
4.1	General CRITICALITY CONSOLE HOUSING FRAME	MCP-9436 & STD-7006	Verify 100%		Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: อ ป. 1 • ธ ป	13 1-21-03
4.2	General CRITICALITY CONSOLE HOUSING FRAME	MCP-9436	Verify 100%		Verfiy that the material is traceable to the approved documentation (CMTR's, P.O's, etc.) Record IR number: ৩১। ৩১-১-১-২৭১	16 1-21-03
5.0	·	MCP-2482	Verify		Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	v1 1-23-03

CONSTRUCTION INSPECT. / PLANNING PACKAGE Page 4 of 4



INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHAU BE PERFORMED UNTIL REASOMABLE ASSURANCE IS ACHIEVED TO: CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
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- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT WUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO ME ITEM.
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- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 101 ALL LINE-OUTS OR WRITE OVERS WAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, A5 A MINIMUM THE FOLLOWING ATTRIBUTES, AB APPLICABLE TO M E EQUIPMENT BEING **INSPECTED:**
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - DI ELEVATION
 - **EI ORIENTATION**
- 131INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT/ COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC. ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A 'GENERAL INSPECTOR'.

CONSTRUCTION INSPECTION PLANNING PACKAGE

May Stay walky Page 1 of 8/16/03

WO/SC/PO No. 021052 Requester: Steve Davies Requester Approvat:

Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility Package, Steel West Shop Inspection

Light/Horn & Alarm Pole Supports

Release Date: 12/11/62

P NO.	P NO. 21052-S-04 Rev. 1		Rev. 1 added additional items for shop inspection			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date	
	SHOP INSPECTIONS			SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL (INFORMATION RELATIVE TO THIS INSPECTION. ALL WELDING PROCESSES SHALL BE DOCUMENTED.		
1.0	Structural Welding	;060	Jerify 100%	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: 02/051-5-/36	KB 1.13-03	
1.1	Structural Welding	:060	/erify 00%	Verify that the filler metal is the correct type per the WPS and that it is traceable to an actual CMTR Record IR number:	1-23-03	
1.2	Structural Welding LIGHT,tIORN & ALARM POLE SUPPORTS	060	/erify 00%	Verify that the welding process is being performed in accordance with the parameters defined in the approved WPS, including the following: a) base metal preparation b) cleaning c) preheat temperature d) interpass temperature e) temporary welds f) backing strips/runoff tabs g) joint preparation 62/ \$53-5-136 Record IR number:	L1 1- 13-03	
1.3	Structural Nelding LIGHT/HORN & NLARM POLE SUPPORTS		100%	single weld. Written approval is required to proceed with more than two repairs. Record IR number:	16 1-23-03	

IP No.	21052-S-04	Rev. 1			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.4	Structural Welding LIGHT/HORN & ALARM POLE SUPPORTS	5060	Verify 100%	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. c base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 1/053 5 6 6 6 6 6 6 6 6 6 6	KO 1-33-03
1.5	Structural Welding LIGHT/HORN & ALARM POLE SUPPORTS	5060 and Approved Shop Drawings S-10, 11 & 8	TPR-4981, Appendix D Visual Random (20% Minimum) Static Loaded HOLD POINT	Visually inspect welds per AWS D1.1. Record IR Number: 31053-5-36 NOTE In-house inspections shall be documented by the Steel West Inspector per the approved vendor data.	/-21-03
2.0	Structural Steel LIGHT/HORN & ALARM POLE SUPPORTS	Approved Shop Drawings S-10, 11 & 8	Verify / Random	Verify that the dimensions shown on the shop the shop drawings are in conformance with the shop drawings and tolerances indicated Record IR number: من المناب المن	12 3 LE LE 12
2 1	Stiuctural Steel and Misc. Metal LIGHT/HORN & ALARM POLE SUPPORTS	Approved Shop Drawings S-3 and S-11 (See AE drawings 522664 & 522665 for additional information)	Verify 100%	Perform inspections specified on the CGI Form 431 53 for the items identifie: below and attach to this plan Document inspections on an IR Form 414 03 1)3-1/2 inch sch. 40 bulk pipe 2) ½ inch sch. 40 pipe nipple— 4 1 1 1 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	NA See Inspection Plan 21052-R- 02 Pb 8/9/
3.0	Structural Steel and Misc. Metal LIGHT/HORN & ALARM POLE SUPPORTS	MCP-9110	Verify Random	Verify that no suspect/counterfeit items have been utilized. Record IR number: つまいままままですが どん まんっぷ	KB (_23-03
4.0		MCP-9436 <i>App.</i> A, B & C		Verify that materials / items are segregated based on quality level, with no co- mingling of quality levels. メイテル・3 Record IR number: 🏎 - 136	1-23-13

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CONSTRUCTION INSPECTION PLANNING PACKAGE

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IP No. 2	21052-S-04	Rev. 1	Rev. 1 added additional it	rems for shop inspection	
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions .	Complete Initial/Date
4.1		MCP-9436 & STD-7006	Verify 100%	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) 62/653-5-/36 Record IR number: 62/653-5-/36	1-23-03
4.2	General LIGHT/HORN & ALARM POLE SUPPORTS	MCP-9436	Verify 100%	Verfiy that the material is traceable to the approved documentation (CMTR's, P.O's, etc.) Record IR number: 021032-3-045	[] -23-43
5.0	General	MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	1-23-03

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP. THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE OF FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43.432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATIONINFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER. ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION/ ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABLITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCHTICKETS).
- 7) M& TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATIONHAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE **BEEN** COMPLETED OR **N/A'D**.
- 10) ALL LINE-OUTSOR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATIONINSPECTIONS SHALL INCLUDE, AS A MINIMUMTHE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLTTORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION

- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT/ COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".

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CONSTRUCTION INSPECTIG

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Final QE Review:

Jay Houswater

Date: 1-24-03

WO/SC/PO No. 021052 Requester: Steve Device Requester Approval: 57 EVE PAUES PSE QE: Ron Staymates 10/21/02 PS Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility Installation Package Release Date: 19/25/02 Release Date: 19/25/02

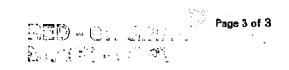
IP No.	21052-5-05	Rev. 0			
item No.	i managanaine	Acceptance Criteria Reference	Melhod/Procedure Reference	Instructions	Complete Initial/Date
***************************************	SHOP			SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL WELDING	
1.0	Structural Welding CRITICALITY ALARM SUPPORTS	5060, pg 3 line 25 thru 36	Verify 100%	Verily that the	1-21-03
1.1	Structural Welding CRITICALITY ALARM SUPPORTS	5060, pg 4 line 30 thru 37	Verify 100%	Verify that the filler metal is the correct type per the WPS and that it is traceable to an actual CMTR. Record IR number: • 2.1 • 5 2 - 5 - 4 4 5	1-11-03
1.2	Situctural Welding CRITICALITY ALARM SUPPORTS	5060, pg 5 line 11 thru 44 & pg 6 line 1 thru 35	Verify 100%	Verify that the welding process is being performed in accordance with the parameters defined in the approved WPS, including the following: a) base metal preparation b) cleaning c) preheat temperature d) interpass temperature e) temporary welds f) backing strips/runoff tabs g) joint preparation Record IR number:	14 50-14-1
1.3	Structural Welding CRITICALITY ALARM SUPPORTS	5060, pg 6 line 37 ihru 42 & pg 7 line 1 thru 12	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: 2.2 -2.1 -2-246	#8 -21-05 494 I MIT

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P No.	21052-\$-05	Rev. 0			
Item No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	netructions	Complete Initial/Date
1.4	Structural Welding CRITICALITY ALARM SUPPORTS	5060	Verify 100%	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number:	124.03
1.5	Structural Welding CRITICALITY ALARM SUPPORTS	5060 and Approved Shop Drawings	TPR-4981, Appendix D Visual Random (20% Minimum) Static Loaded HOLD POINT	Visually inspect welds per AWS D1.1. Record IR Number: p>1e62-x-500 NOTE: in-house inspections shall be documented by the Steel West Inspector per the approved vendor data.	1-21-03
2.0	Structural Steel CRITICALITY ALARM SUPPORTS	Approved Shop Drawings	Verify / Random	Verify that the dimensions shown on the shop the shop drawings are in conformance with the shop drawings and tolerances indicated. Record IR number: >21053.5.5455	14
3.0	Structural Steel and Misc. Metal CRITICALITY ALARM SUPPORTS	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: ਕਰਮਕਾਰ-ਤ-ਕਰੋ	25-03
4.0	General CRITICALITY ALARM SUPPORTS	MCP-9436 App. A, B & C	Verify Random	Verify that materials / items are segregated based on quality level, with no cominging of quality levels. Record IR number عمادود الله عمادود الله الله الله الله الله الله الله الل	1.21.03
4.1	General CRITICALITY ALARM SUPPORTS	MCP-9436 & STD-7006	Verify 100%	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number (1990) - 1995	1.21.03
	CRITICALITY ALARM SUPPORTS	MCP-9436	100%	Verify that the material is traceable to the approved documentation (CMTR's, P.O's, etc.) Record iR number: ショックコン・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・	کالا له سرد،
5.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	1-23-00

CONSTRUCTION INSPECTION PLANNING PACKAGE



INSPECTION PLAN GENERAL NO

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION [HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHAU ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABLITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-638 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR NIA'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS QR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUWE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE. HYDROSTATIC. PNEUMATIC; ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A 'GENERAL INSPECTOR".

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Final QE Review: - Jay May

Date: 12 - 16 - 02

WO/SC/PO No. 021052 Requester: Steve Davies Requester Approval: STEVE DAVIES PEC QE: Ron Staymates 10/31/02
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (DCN FS-19)
KACEN SHRUPSHIRE WHAT
Release Date: 11-9-03-

P No.	21052-S-06	lev. O			
No.	Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
		i		SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL WELDING PROCESSES TO THE FLOOR STRUCTURE SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE	N/A
1.0	Structural Welding Pet DCN FS-19	5060	'erify 00%	DRAWINGS. Verify that the welders are qualified to perform the welding process and have a current qualification and has been approved in the vendor data system Record R number: 02(052-5-01-9)	12-12-03 CEL
1.1	Structural. Welding Per DCN FS-19	5060	'erify landom	Verify that the filler metal is the correct type per the WPS and that it is traceable to a CMTR and has been approved in the vendor data system. Record IR number. 0 2/052-8-019	12-12-9 CER
1.2	Structural Welding Fer DCN FS- 9	5060	erify landom	Verify that the welding process is being performed in accordance with the parameters defined in the approved vendor data WPS, including the following: a) base metal preparation 12 - 12 - 12 - 12 - 12 - 12 - 12 - 12	12-12-0 CEL
1,3	Structural Welding Per DCNFS-19	060	erify 00%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: $02/0.52-5-0.29$	12-12-0 CEL
1.4	Structural Welding Per DCN FS-19	060	erify landom	Verify that are strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Are strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld detect and repaired as specified. Record IR number: 021052-5'-029	12-12-01 CER

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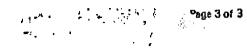
P No.	?105?-S-06	Rev. 0			
Item No.	Process/item/ Material or Equipment	Adceptence Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.5	Structural Welding Per DCN FS-19	5060	TPR-4981, Appendix D Visual 100% Static Loaded HOLD POINT	Visually Inspect pipe sleeve welds per AWS D1.1. Record IR Number: See TP 021055-5'-01 Verify that no suspect? counterfelt #ems have been utilized.	N-A
2.0	General	MCP-9110	Verify Random	Verify that no suspect? counterfelt items have been utilized. Record IR number: 02/052-5-025	12-12-02
3.0	General	MCP-9436 App. A, B & C	Verify Random	Verify that materials / items are segregated based on quality level, with no co- imingling of quality levels.	12-12-02 CEN
4.0	Ganeral	MCP-9436 ADD. A. B & C And STD-7006	Verify Random	Record IR number: 02/052-5-025 Verify that I acceptility markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: 12/052-5-025	12-12-02
5.00	General	MCP-2482	Verify	Record IR number: 02/052-5'-029 Verify that all inspections have been completed and forward this inspect on plan	12-12-02

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECT ONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION | HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION/ ACCEPTANCE SHAU ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COW OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABLITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS):
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECCRDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-638 / 598.
- 91 ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE SEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTEO, AS APPLICABLE, PR OR TO PERFORMING INSPECTIONS.

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- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - **5) ANCHOR BOLT TORQUE**
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OF COMPONENTS PER MCP-9110.
- 14) A U ATTRIBUTES (N 1HIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION. (I.E. WELDING. NDE. HYDROSTATIC. PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A 'GENERAL INSPECTOR'.
- 15) CHECKLIST 414.A15 IS BEING PILOTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE.

CONSTRUCTION INSPECTION PLANNING PACKAGE

Final QE Review:

Date: 4-28-03

WO/SC/PO No. 021052 (Requester: Steve Davies Requester Approval: 57 EV DAVIES DE EMAIL QE: Ron Staymates 10/25/02 FL
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility Package, Atlas Shop Inspection

| Wo/SC/PO No. 021052 | CRON Staymates 10/25/02 FL
| Release Date: //-6-02

PNo. 2	21052-V-01	₹ev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.0	SITUCTURAL SITUCTURAL Welding STAINLESS S1 EEL DUCTWORK Structural	15014	/erify 100%	SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL WELDING PROCESSES SHALL BE DOCUMENTED. Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: \$1/057 - V - 041 Verify that the filler metal is the correct type per the WPS and that if is traceable	11-6-02 11-6-02
	Welding STAINLESS STEEL		100%	to an actual CMTR Record IR number: 010 01/01-1-1-0-1-0-1-0-1-0-1-0-1-0-1-0-1-0-	1-6-0 I
1.2	Structural Welding STAINLESS STEEL DUCTWORK	5014	'erify 00%	Verify that the welding process is being performed in accordance with the parameters defined in the approved WPS, including the following: a) base metal preparation b) cleaning c) preheat temperature d) interpasstemperature e) temporary welds 9 backing stripshunoff tabs g) joint preparation Record IR number:	18 23403
1.3	Structural Welding STAINLESS STEEL DUCTWORK	15014	'erify 00%	Verify that any weld repairs are limited to a maximum d 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: しょうフェンショリ	1-24-03

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CONSTRUCTION INSPECTION PLANNING PACKAGE

Page 2 of 3

	Record IR number: 03/053-0-39	1/21/ fg (201313/ 12/)		ристмояк	
ĺ	their unique identifier) 2/e52-h-13			STEEL	
امر ور د	transferred when material is subdivided. (transfer can be by marking, tagging or	%00 l	8 STD-7006	SESTMIATE	
40-45.24-03	Verify that traceability markings (QA numbers, heat numbers, etc.) are	Verify	MCP-9436	General	1.4
	05-0-250126			ристмовк	
	у питрет:			STEEL	
80-68-5	mingling of quality levels.	Random	App. A, B&C	STAINLESS	
20	Verify that materials / items are segregated based on quality level, with no co-	Verify	WCP-9436	General	0.4
	18-7-250129			DUCTWORK	
		į		STEEL	
ام				STAINLESS	
E0-42 5	Record IR number:	Random		and Misc. Metal	
97	Verify that no suspect / counterfeit items have been utilized.	Verify	MCP-9110	Structural Steel	0.6
	he -1 - 150/t 0	į	ľ	DUCTWORK	
اع مرد د د د	Record IR number: @1/@11-0-044		-6	STEEL	
2.44.03	conformance with the shop drawings and tolerances indicated.	Random	Drawings	STAINLESS	0.4
	Verify that the dimensions shown on the shop the shop drawings are in	Verify	doug pavoiddy	Structural Steel	0.5
	serified		* 952/1]	DUCTWORK	
I	Record IR number: @21027-14-014 19 200	2/ 22 /		STEEL	
	design change document (DCN / FCR). れ	100%		Welding ESS	
E0.44.E	removable color contrast penetrant. Acceptance criteria will be defined on a	Visual	12014	Structural	7.1
	Liquid Penetrant examine the final pass on all welds, using water washable	HOLD POINT	71031	ристмовк	
	Reculo in Mulliper. S. 2.5.2 - 12 Web.	Static Loaded		STEEL	
	Record 18 Namber: 621051-17-012 4164 To istace the melded adjacent to the weld	100% 100%	Drawings	STAINLESS IN	
ام	NOTE: Welder identification and Weld identification are required to be vibro-	Visual	Approved Shop	Welding O	
50-42-8	Visually inspect welds per AWS D9.1 (copy stached).	186 1 -991	15014 and	Structural	9.1
	15-4-17- 7 / OC O/10 11 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1			DUCTWORK	
	and the second			STEEL	
	Record IR number: 07/051-H-012			STAINLESS	
80-45-E	been removed and the base metal ground smooth and flush.	mobns Я		Welding	
07	Verify that any temporary welds utilized during the tabrication process have	Verify	12014	Structural	S.1
	Record IR number: 62/6/27 - H-0/2 to 4-6-6			DUCTWORK	
ļ	specified.		}	STEEL	
. [in, into the base metal shall be considered as a weld defect and repaired as			STAINLESS	
80-15-5	1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32	%00L		Welding	
لاه	Verify that arc strikes have been ground to a smooth contour but no more than	Verify	12014	Structural	<u> 4.1</u>
ets (() () () () () ()		Reference	eonereleR	Equipment	OV.
Complete ots:(I)	snoibonisni	Method/Procedure	Criteria	Material or	weŋ
ر دستاری			Acceptance	Process/Item/	

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IPNo.	21052-V-01	Rev. 0	ļ		
item No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	. Instructions	Complete Initial/Date
4.2	General STAINLESS STEEL DUCTWORK	MCP-9436	Verify 100%	Verify that the material is traceable to the approved documentation (CMTR's, P.O's, etc.) Record IR number: カンリャデコー パー 0/0	1-13.03
5.0		MCP-2482	Varify	Verify that all inspections have been completed and forward this inspection plan to the QE for dosure.	2.34.63

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFURMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 21 ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTIONREPORT" ENDIAT-ACHED TO THE APPLICABLE CIP, INSPECTION REPORTS SHALL BE COMPETED AT LEAST DAILY. ANY IR REQUIRING ACT ON SHALL BE FORWARDED TO THE DE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS [FORM432.43, 432.44 AND 432.45]
- 4) WITCH DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OF OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NCIMEER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ARY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 61 ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABLITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE. **BATCH TICKETS).**
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 91 ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-QUIS OR WHITE OVERS HAVE BEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE REEN APPROVED OF SUBMITTED, AS APPLICABLE, PRIOF TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE. AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORCUÉ
 - C) LOCATION
 - D) ELEVATION
 - E) OFIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPTTHOSE THAT REQUIRE A SPECIFIC QUALIFICATION. (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNELQUALIFIED AS A 'GENERAL INSPECTOR'.

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Page 1 of 3

Rev. WOT

414.81# 09/08/97

Final QE Review:

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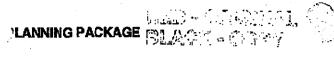
Date: 4-9-03

WO/SC/PO No. 021052 Requester: Steve Davies Flequester Approval: Stoff JEUSEN PEZ EMAIL QE: Ron Staymstoe 12/16/02 F/K
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (ICR-005 REWORK ACTIVITIES)
Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2)

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liem Na.	Process/Item/ Material or Equipment	Acceptance Oritoria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION.	
· ·				ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELDING PROCESSES SHALL RE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS,	
		·		THESE STEPS MAY BE WORKED IN ANY SEQUENCE NECESSARY TO COMPLIETE THE WORK ACTIVITIES	•
1.0	RCS Panel · WF-02	ICR-065 (COPY ATTACHED)	Verify Random	Varify that the panel has been reworked in accordance with the ICR.	3-6-0. CEK
1.1	RCS Panel WF-02	ICR-065	Verly Random	Verity that the rivets are installed per the ICR.	3-6-03 CER
1.2	RCS Pariel WP-02	ICR-065	Verify Random	Verify that the caulking has been installed per the ICR.	3-6-03 CEL
2.0	RCS Panel 1 WP-106	ICR-065	Verify Rendom	Verify that the panel has been reworked in accordance with the ICR.	3-6-03 EA
2.1	RCS Panel IVP-108 IVP-108	ICR-065	Verify 100%	Verify that the rivets are installed per the ICR.	3-6-03 CER
2.2	RCS Panel WP-106	ICR-065	Verify Rendom	Verify that the caulking has been installed per the ICR.	3-6-03 CER
3.0	RCS Panel WP- (od	ICR-085	Verify Random	Verify that the panel has been reworked in accordance with the ICR.	CER

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ltem No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
3.1	RCS Panel WP-100	ICR-065	Verify Random	Verify that the rivets are installed per the ICA.	1-16-05 CEN
3.2	RCS Panel WP-100	ICR-085	Verify Random	Verify that the caulking has been installed per the ICR.	1-16-03 CEL
2.0	HCS	MCP-9110	Verity Random	Varify that no suspect / counterfeit items have been utilized." Record IB number: N-4. CEL	I-la-
3.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the GE for closure.	- -93 EE

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL RE PERFORMED UNTIL REASONABLEASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL SE DOCUMENTED DN FORM 414.03, "QUALITY INSPECTION REPORT" AND AT IACHED LOTHER APPLICABLE CIP. INSPECTION REPORTS WALL BE COMPLETED AT LEAST DAILY ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QUE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FOAM 414,04 "VISUAL INSPECTION REPORT" AND ATTACHED TO MEAPPLICABLE CIP OR ON -HE WELD HISTORY RECORDS (FORM 43243, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INGLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION(HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO RE DOCUMENTED ON FORM 4'4 OR OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- E) A FIACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: RATCHTICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- δ) NCF / DR INFORMATION HAS BEENRECORDED PER MCP-538 / 598.
- 2) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEENINITIALED AND DATED.
- 11) YERIFY THAT APPLICABLE VOS DOCUMENTSHAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE,AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - R) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION

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13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENMALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MICP-9110.
14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDF, HYDHOSLALK), FINEL MATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "SENERAL INSPECTOR".
15) OI IECKLIGH 414.A15 IS BEING FILOTED IN THIS INSPECTION FLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE GRAND THE RE.

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414.81# 09/08/97 Rev. #01

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Final OE Review:

QE: Ron Staymates 11/11/02

12-5-02 Release Date:

WO/SC/PO No. 021052
Adivity/Project Description: OU 7-10 Glovebox Excavator Method Facility (ICR-062 REWORK ACTIVITIES)
Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2)

IP No.	IP No. 21052-M-06	Rev. 0				ſ
lien .vo.	Process/Remi Malerial or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Inital/Date	e (i)
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION.	-	
				ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSECUENCE WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS.		
······································				THESE STEPS MAY BE WORKED IN ANY SEQUENCE NECESSARY TO COMPLIETE THE WORK ACTIVITIES		
-0	RCS Pane	ICR-062	Varify	Verify that the silicone caulk is removed per step 1.	D-51-11	⁷
	WP-23		Random	28 021052-5-043	CER	
=	RCS Pane	ICH-062	Vairity	Venty that the rivets are removed per step 2.	1-15-0	3
	WP.23		Random	18 0210525-043	CEK	
٦,٢	HCS Fane.	ICR-062	Verify	Verlify that the sheeting is removed per step 3.	1-1503	21
	WP-25		Handom	EN 0210525-043	J. J.	
<u>-</u>	ACS Fanel	ICR-c62	Verify	Verify that the remaining caulk is removed per step 4.	9-51-1	6
•	WP-25		Handom	IN 021052-5-043	CER	
4.14	RCS Fanel	ICR-C62	Verify	Verify that the sheet is rotated 180 degrees per step 5.	25/-/	2
··· • · · · · ·	WP-23			TR 021055-5-043	CEK	
1.5	RCS Panel	ICR-C62	Verify	Verify that the sheet is shimmed per step 6.	1-15-03	3
···········	WP-23	الله المناب	Handom	IR 021052-5-043	CEK	
1.6	RCS Panel	ICR-C62	Verify	Verify that the sheet is centered per step 7.	7-12-6	7
	WP 23		Handom	TO 02 1057-5-042	The second	<u></u>

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P No.	21052-M-06	Rev. 0			
item No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.7	RCS Panel WP-23	ICR-062	Verity Random	Verify that the holes are drilled per step 8. IR 02/052-5-043	1-15-03 CEA
1.8	RCS Panel WP-23	ICR-062	Verify Random	Verify that the sheet is caulked per step 9.	1-15-03 CFA
イ.9	RCS Panel WP-23	ICR-062	Verify 100%	Verify that the rivets are installed par step 10. TR 02/052-5-043	1-15-03
1.10	RCS Panel WP-23	ICR-062	Verify Random	Verify that the holes are drilled out per step 11. TR 021052-5'-093	1-15-03
1.11	RCS Panel WP-23	ICH-062	Verify 100%	Verify that the rivels are installed per step 12.	1-15-03 PFA
1.12	RCS Panel WP-23	ICR-062	Verify 100%	Verify that the sheet is caulked per step 13.	1-15-03
/2.0	RCS	MCP-9110	Verify Random	Verify that no suspect / counterfelt items have been utilized. Record IR number: 7 1/055-5-043	1-15-03
√3.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure. 2/055-5-043	1-15-03

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORYON THE CIP, THEN ADDITIONAL INSPECTIONSWALL BEPERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORTS AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE OE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM414.04 VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABLITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCHTICKETS).

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- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED ?ER MCP-538 / 598.
- 9) ALL BUNKS HAVE BEEN COMPLETED OR WA'D.
- 10) ALL LINE-OUTS OF WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFYTHAT APPLICABLE VDS DUCUMENTS HAVE B E N APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUMTHE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
- A) ANCHOR BCLT PLACEMENT
 - B) ANCHOR BOLT JOROUE
 - C) LOCATION
 - D) ELEVATION
 - E) CRIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT/COUNTERFEIT PARTS OR COMPONENTS PER MCP-0110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, N.D.E., HYDROSTATIC, PNFUMATIC, ETC.) MAY DE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR"
- 15) CHECKLIST 414.A15 IS BEING PILOTED IN THIS INSPECTION FLAN (REF. TPR-4921). AND SUBJECT TO CLAPIFICATION / REVISION DUFING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THEOR AND THE RE.

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Page 1 of 2

Final QE Review:

Date: 4-9-03

WO/SC/PO No. 021052 Requester: Steve Davies Requester Approval: MARCH SHOOFSHIRE PER CHARGE: Ron Staymates 12/19/02 //
Activity/Project Description: CU 7-10 Glovebox Excava:or Method Facility (ICR-041 REWORK ACTIVITIES)

Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2)

Release Date: 12-19-02

IP No. :	21052 -M- 38	Nev. 0			*
	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAM FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION.	
				ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 ANC 432.45 OR FORM 432.43 OR THE DRAWINGS.	
				THESE STEPS MAY BE WORKED IN ANY SEQUENCE NECESSARY TO COMPLTETE THE WORK ACTIVITIES	
1.0	WES	ICR-041 (COPY ATTACHED)	Verily Random	Verify that the snow shields and penetrations have been installed per the ICR, item 1.	2-6-03 CEL
1.1	WES	ICR-041	Verify Random	Verify that the door sweeps have been installed par the ICR, item 2.	2-6-03 CER
1.2	WES	ICR-041	Verify Random	Verify that the pressure plates have been installed per the ICB, item 3.	2-6-03 CEL
2.0	WES	MCP-9110	Verify Rardom	Verify that no suspect / counterfeit items have been utilized. Record IR number: 02/052-5-045	2-8-2
3.0		MCP-2452	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	2-6-0°

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING 5-HALL BE DCCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORTS" AND ATTACHED "TOTHE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BEFORWARDED TO THE QE FOR RESOLUTION.

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- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 'VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION/ ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABLITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M& TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / OR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BUNKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFYTHAT APPLICABLE VDS DOCUMENTSHAVE BEENAPPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPUCABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - **B) ANCHOR BOLT TORQUE**
 - C) LOCATION
 - D) ELEVATION
 - E ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT/COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".
- 15) CHECKLIST 414,A15 IS BEING PILOTED IN THIS INSPECTION PLAN (REF-TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE.

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. (/14.81); G3/08/97 Piev. #01 CONSTRUCTION INSPEC - A PLANNING PACKAGE Page i of 2 Final QE Review: WO/SC/PO No. 021052 Requester: Steve Davies Requester Approval: **AREX SHOPSINE FOR Activity/Project Description: OU 7-10 Glovebox Excavato: Method Facility (DON FP-17)

Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2) QE: Ron Staymates 12/19/02

ltem No.	Process/Lenv Material or Equipment	Rev. 0 Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
			A	SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION.	-
				ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS.	
1.C	Stud Wolds	DCN FF-17 and AWS C5.4 (copy attached)	Variy 100%	Verify that the mechanical test specified in section 9 is performed and acceptable prior to each initiation of production wolding. Record IR number: (12/052-5-073	3-41-03 CEL
1.1	Stud Welds	DCN =P-17 and AWS C5.4 (copy attached)	Verify 100%	Verify that the requirements of AWS C5.4, section 6 are being complied with, including base metal prep, equipment setup, etc. Record IR number: (1 - (1 - (2 - 5 - 7))	3-41-03 CFR
1,2	Stud Welds	DGN FP-17 and AWS C5.4 (copy attached)	Venity 100%	Verify that the recuirements of AWB 05.4, section 8 are being complied with, including locating, perpendicularity, accessories, etc. Record IR number: (1) 2/1/10 5 S7/93	CER
1.3	Stud Weds	CCN FP-17 and AWS C5.4 (copy attached)	TPR-4981 Visual 100% Static Loeded HOLD POINT	Visually inspect weids per AWS C5.4, section 9. Record IR Number: 07/052-5-093	3-4-0. CER
2.0	Structure! Steel	MCP-9110	Verify Random	Verily that no suspect / counterfeit items have been utilized. Record IR number: () 2 10 5 5 - 5 - 0 72	3-4-0
3.0	General	MCP-9433 App. A, B & C	Verify Random Checklist 414,A83	Verify that materials / items are segregated based on quality level, with no co-mingling of quality levels. Record IR number: ()2/055-5-073	3-4-03 CER
3.1	General	MCP-9435 App. A, B & C And STD-7003	Verify Rondom Chacklist 4: 4.A33	Verify that fraceability makings (CARLEBERS, heat numbers, stc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other un que identifier) Record IR number: (2405) -5 -93	3-409 CFL
				Nelson Steeds And Eguip. news Netilized 3-4-03 CER	gent

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tem No.	Process/item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
4.0		MCP-2482	Verify	Ve ify that all inspections have been completed and forward this inspection plan to the QE for closure.	3-4-03

INSPECT IN PI AL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BEPERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 21 ALL INSPECTIONS, EXCEPT WELDING SHALL BE DCCUMENTED ON FORM 414,03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP, INSPECTION REPORTS SHALL BE COMPLETED AT LEASTDALY, ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR OM THE WELD HISTORY RECORDS (FORM 432,43, 432,44 AND 432,45)
- 41 WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER DENTIFICATION INFORMATION [HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGNICHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE OIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTSM A TWILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- /) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) WOF / DR INFORMATION HAS REEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR NIA'D.
- 10) ALL LINE-CUTS OR WRITE OVERSHAVE BEEN INITIALED AND UP IEU.
- 11) VERIFY THAT APPLICABLE VD\$ DOCUMENTS HAVE BEENAPPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALIATION INSPECTIONS SHALL INCLUDE. AS A MINIMUM M. E FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - **B)** ANCHOR BOLTTORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT/COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES INTHIS PLAN, EXCEPTTHOSE THAT HEQUIRE A SPECIFICQUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, LTC.) MAY BE PERFORMED BY PERSONNELQUALIFIED AS A 'GENERAL INSPECTOR'.
- 15) CHECKLIST 414 A45 S BEING PILOTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE.

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414.b1∌ 09/08/97 Rev. #01	CONSTRUCTION I	NSPECTION ANNING PACKAGE		ige 1 of S	ļ
19 L		Final QE Review: Noy Meyra	7	Date: 1-9-03	_
WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: STEVE DAVIES FOR	e outsil	QE: Ron Staymates 10/03/02	
		Facility Structures (FCR 13233-90) enacquence (Q31 / RCS is sefety significant (02) 1/27/03	Release Date: 1/27/03	

P NO.	21052-M-10	Rev. D			
It em No.	Process/item/ Materialor Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL N M L S PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION.	
	•			ALL WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAW:NGS.	
1.0	Stainless Structural Steel (ref: Spec. 5060 criteria listed above)	5060	/erify landom	Verify that the welders are qualified to perform the welding process and have a current qualification.	2-5-03 CER
1.1	Stainless Structural Steel (ref: Spec. 5060 critaria listed above)	5060	'erify tandom	Verify that the filler metal is the correct type per the WPS and that it is traceable to an actual CMTR with heat number. Record IR number: 02/052-5-092	2-5-03 CER
1.2	Stainless (Structural Steel (ref: Spec. 5060 criteria listed above)	5060	rerify Pandom	Verify that the welding process is being performed in accordance with the parameters defined in the WPS (S-3.16 stainless or CS-3.04 carbon to stainless), including the following: a) base metal preparation 2-5-03 CFF b) cleaning c) preheat temperature d) interpass temperature e) temporary welds f) backing strips/runoff tabs WFF g) joint preparation 1-5-03 CFF Record IR number: 02/052-5-092	2-5-03 CER

P NO.	21052-M-10	Rev. 0]		
ltem NO.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.3	Stainless Structural Steel (ref: Spec. 5060 criteria listed above)	5060	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more Mantwo repairs. Record IR number: 02-1052-5-042	2-503 CEL
1.4	Stainless Structural Steel (ref: Spec. 5060 critena listed above)	5060	Verify Random	that: strikes have been ground to a but no more than /3.2 in. of base metal shall removed. Arc strikes fir n than 1/32 in. into the ase r shall be considered a weld defect and repairs as cified Record R number:	2-5-03 CER
1.5	Stainless Structural Steel (ref:Spec. 5060 criteria listed above)	5060	Visual 100% MOLD POINT Static Loaded	Visually of welds per AWS U1.6 utilizing II ed a if criteria section 6.26 (St Load d Record IR Number:	2-503 CEL
1.6	Stainless Structural Steel	MCP-9110	Verify Random	Verify that no suspect/counterfeit items have been utilized. Record R number: 62/052-5-042	2-5-23
2.0	General	MCP-9436 App. A, B & C	Verify Random Checklist 414.A33	Verify that materials/items are segregated based on quality level, with no cominding of quality ~ e v e [~ . Record IR number: () 24052-5 - 042	2-5-05 CEL
2.1	General	MCP-9436 App. A, B <i>a</i> C And STD-7006	Verify Random Checklist 414.A33	Verity that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided, (transfer can be by marking, tagging or other unique identifier) Record IR number: () 2//52-5-042	2-5-03 CEL
3.0		MCP-2482	Verify	Verify that ail inspections have been completed and forward this inspection plan to the QE for closure.	2-5-03 CEX

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORYON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLEASSURANCE IS ACHIEVED TO CONFIRM COMPUANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPTWELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM. 22-0358052 LMIT

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- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHAU ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABLITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR/DR INFORMATION HAS BEEN RECORDED PER MCP-538/598.
- 9) ALL BUNKS HAVE BEENCOMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEENINITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, A 3 APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATIONINSPECTIONS SHALL INCLUDE, AS A MINIMUMM E FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT/ COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES INTHIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".
- 15) WHEN CONFLICTS ARISE THAT PRECLUDE THE INSPECTOR FROM PERFORMING A VERIFICATION ACTIVITY, THE INSPECTOR IS ALLOWED TO DOCUMENT COMPLETION OF INSPECTION STEPS, BASED ON OBJECTIVE EVIDENCE FROM THE COGIZANT STR OR QE THAT THOSE STEPS HAVE BEEN COMPLETED AS DESCRIBED IN THE INSPECTION PLAN. ATTACH COPIES OF THE OBJECTIVE EVIDENCE TO THIS PLAN.

710GEM-19-0029

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CONSTRUCTION INSPECTION PLANNING PACKAGE

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Final QE Review: Noy Maywaley

Date: <u>3/5/63</u>

WO/SC/PO No. 021052
Requester: Steve Davies Requester Approval: STOJE DAVIES PER TELEGIA QE: Ron Staymates 2/17/03
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility
(GLOVEBOX LEAK TESTING ACTIVITIES)
Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2)

Release Date: 2 -/8-0 3

IP No.	21 052-M-11	Røv, 0			
Item	Process/Item/ Materialor Equipment	Acceptance Criteria Reference	Method/Procedure Reference	· instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION.	
,		1		ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELDING PROCESSESSHALL BE DOCUMENTED ON FORMS 432.44 AND 43245 OR FORM 432.43 OR THE DRAWINGS.	
1.0	Glovebox Number 1	IPP 21052-M-03	Verify 100%	Verify that all Inspections on 21052-M-03 have been completed for Gloveoux number 1.	N/A installation still in-process
2.0	Glovebox Number 2	IPP 21052-M-03	Verify 100%	Verify that all inspections on 21052-M-03have been completed for Glovepax number 2.	N/A installation still in-process
3.0	Glovebox Number 3	IPP 21052-M-03	Verify 130%	Verify that all inspections an 21.052-M-03 have been completed for Glovecax	N/A installation still in-process
4.0	Glovebox ,Number 1	Approved Test Procedure	Venty 100%	Verify that the glovebox, including windows and gloveports is Leak Tested in accordance with the manufacturers instructions. Record IR number: (2) 10 52 - M - 05/	2-76-83 CER
5.0	Glovebox Number 2	Approved Test Procedure	Verify 1UQ%	Verify that the glovebox, including windows and gloveports is Leak Tested in accordance with the manufacturers instructions. Record IR number: 6 2/652-M -09/	2-26-03 CER
6.0	Glovebox Number 3	Approved Test Procedure	Verify 100%	Verify that the glovebox, including windows and gloveports is Leak Tested in accordance with the manufacturers instructions. Record IR number: (22/052-M-09/	2-260) CEX
7.0	General	MCP-9110	V∋rify Random	Verify that no suspect / counterfeit iforms have been utilized. Record IR number: 0 2/0 53 M -05/	2-36-93
8.0		MCP-2482	Varify	Verify that all inspections have been completed and forward this inspection plan to the CIE for closure.	2-2-2013

CONSTRUCTION INSPECTION PLANNING PACKAGE



Page 2 of 2

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCEWITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CJP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE OE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUALINSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDETRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION LACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTSTHAT WILL PROVIDE TRACEABLITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCHTICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BUNKS HAVE BEEN COMPLETED OR NIA'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VOS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATIONINSPECTIONS SHALL INCLUDE, AS A MINIMUMTHE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - 8) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPTTHOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".

414.61# 09/08/87 Rev. #01	CONSTRUCTION	INSPECTIC /1	ANNING PACKAG	E (1990 - 0)		○ Page 1 of 3
4-		Final QE Review:_	May They	males	_ Date:	.3/5/03
WO/SC/PO No. 500-021052	Requester: S Davies	Requester Appro	val: TOM HIPPAR	EMAL 7963 74 OE:	Ron Staymates	P.
Activity/Project Description: OU 7-	10 Glovebox Excavator Method	Facility Package Re-	celpt Inspection Activiti	es (Misc. CAS		9
Electrical (tems)	,			Rele	ase Date: 2/5/20	03

	财	116/03			
No. 2	21052-R-9304	Flev. 0	•		
Item No.	Process/Item/ Materialor Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Dat
N/A	₩A	NVA	N/A	subcontractor material that is safety class (Q-1), safety significant (Q-2) or low safety consequence (Q-3) requires receipt inspection. This includes the following items, as a minimum: (see Form 414.02 & 414.70 for details) 1) Inspector shall record the following information on the Inspection Report: A) Item description B) VDS item number, as applicable C) Quantity inspected D) Serial numbers/unique Identifying numbers	N/A
1.0	Misc. CAS Electrical Rems Warbonnet, Electrical) ? 3EF FCR- 13233-f 18 AND 13233-96	PR-6416	'isual / 100%	Verity the following conditions, as applicable 1) Damage 2) Cleanliness 3) protective coating 4) markings / identification 5) dimensional (random] — utilize approved fab drawings, cataloguecuts, etc. 6) surface condition / finish 7) weld appearance 8) end protection 9) end preparation 10) storage level & segregation per MCP-9436 (this is not an accept/reject attribute. If material is not being segregated, document on an IR and forward the IR to the QE) IR number. 02-1052-2-2-27	714 2/18/03
1.1	⊃er VDS	PR-6416	Visual/ 100%	Verify that the material is traceable to the associated documentation, and that it complies with the approved vendor data. IR number: 02/652-5-0 57	2/18/0

CONSTRUCTION INSPECTIO. . . LANNING PACKAGE



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P Nu. 2	1052-R-93 04	Rev. <i>o</i> '			
Item No.	Process/Item/ Material or Equipment	. Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.2	For Form 431.53 For Drawing 522770, dated 2/4/2003 and for Drawing 522777, dated 2/3/2003	TPR-6416	Verify / 100%	Perform Inspections specified an the CGI Forms 431.53, for the items identified on the CGI forms. Document inspections on an IR Form 414.03. Record IR numbers: 62/352 - 2-257	M 211863
13	Per Form 414.02 and / or 414.70	TPR-8416	Verify / 100%	Apply a QC Accept tag to the items, where practical. When this is nat feasible, the tag shall be placed with the inspection report for future reference. NOTE: All items accepted shall be uniquely identified to indicate acceptance. This identification shall consist of either placing a tag, where possible or by applying the QA number and initial/date physically on the item with a black indelible marker.	2/1/63
2.0	Inspection Plan	MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plant to the QE for closure.	3/4/03

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLEASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL SE DOCUMENTED ON FORM 414.04 VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CJPOR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDEL COATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION[ACCEPTANCE SHALL ALSO BE DOCUMENTED ON THE APPLICABLE CIPATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABUTY OR CLAFIFICATION OF INSPECTIONS PERFORMED (IE: BATCHTICKETS).
- 7) M 6 TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- B) NCR / DR INFORMATIONHAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) WHEN PERFORMING LIQUID PENETRANT EXAMINATION RECORD THE BATCH NUMBERS ON EITHER THE WELD HISTORY RECORD OR THE IRLOR

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CONSTRUCTION INSPECTIC. LANNING PACKAGE

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THE CIP

- 11) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 12) VERIFYTHAT APPLICABLE VDS DOCUMENTSHAVE BEEN APPROVED OR SUBMITTED AS AFPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 13) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TOROUS
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 14) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT/COUNTERFEIT ITEMS PER MCP-9:10.
- 15) ALL ATTRIBUTES IN THIS PLAN. EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY QUALIFIED PERSONNEL OTHER THAN A "GENERAL INSPECTOR".
- 16) WHEN CONFLICTS ARISE THAT PRECLUDE THE INSPECTOR FROM PERFORMING A VERIFICATION ACTIVITY, THE INSPECTOR IS ALLOWED TO DOCUMENT COMPLETION OF INSPECTION STEPS. BASED ON OBJECTIVE EVIDENCE FROM THE COGIZANT STRONG OF THAT THOSE STEPS HAVE BEEN COMPLETED AS DESCRIBED IN THE INSPECTION PLAN. ATTACH COPIES OF THE OBJECTIVE EVIDENCE TO THIS PLAN.